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Forney

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(54) **SYSTEMS AND METHODS FOR
DISINFECTION**

(75) Inventor: **Larry Forney**, Doraville, GA (US)

(73) Assignee: **Georgia Tech Research Corporation**,
Atlanta, GA (US)

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U.S.C. 154(b) by 543 days.

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claimer.

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Related U.S. Application Data

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is a continuation of application No. 10/692,983, filed
on Oct. 24, 2003, now Pat. No. 7,001,571.

(60) Provisional application No. 60/974,891, filed on Sep.
25, 2007, provisional application No. 60/461,362,
filed on Apr. 8, 2003, provisional application No.
60/420,985, filed on Oct. 24, 2002.

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C02F 1/00 (2006.01)

C02F 1/34 (2006.01)

C02F 1/48 (2006.01)

A61L 2/00 (2006.01)

(52) **U.S. Cl.** **210/748.11; 210/748.01; 210/748.1;**
422/22; 422/24

(58) **Field of Classification Search** 422/22,
422/24; 210/748.01, 748.1, 748.11
See application file for complete search history.

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Primary Examiner — Kevin Joyner

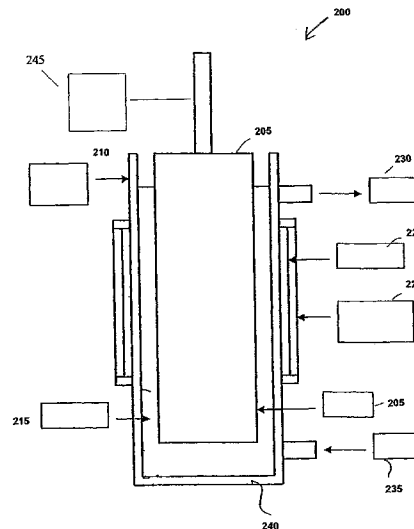
Assistant Examiner — Regina M Yoo

(74) *Attorney, Agent, or Firm* — Thomas, Kayden,
Horstemeyer & Risley, LLP

(57) **ABSTRACT**

Methods and systems for establishing Taylor-Couette flow in
a fluid are provided. Aspects of the disclosed methods and
systems incorporate laminar Taylor-Couette flow in combi-
nation with a source of radiation to provide more uniform
radiation exposure to the fluid and its components. Common
problems of non-uniform radiation levels and concentration
boundary layer effects in UV reactors are largely eliminated
using the methods and devices provided herein. In an exem-
plary embodiment, the reactor of the present disclosure has a
hollow outer cylinder or stator and a rotor positioned therein
and smooth walls for both the outer wall of its rotor and the
inner wall of the outer cylinder or stator in which the rotor is
positioned, the space between which forming the annular
fluid gap.

20 Claims, 29 Drawing Sheets



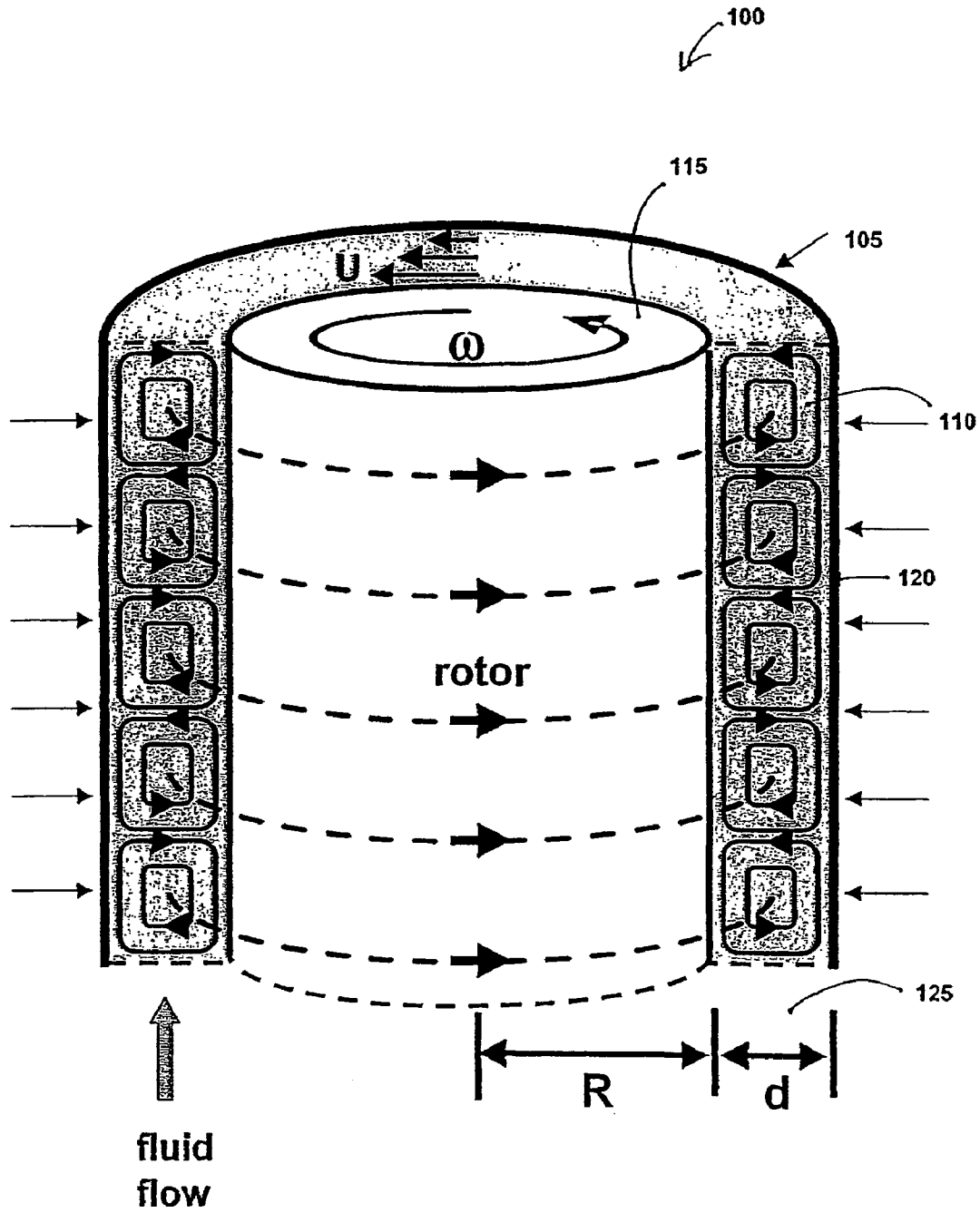


Figure 1A

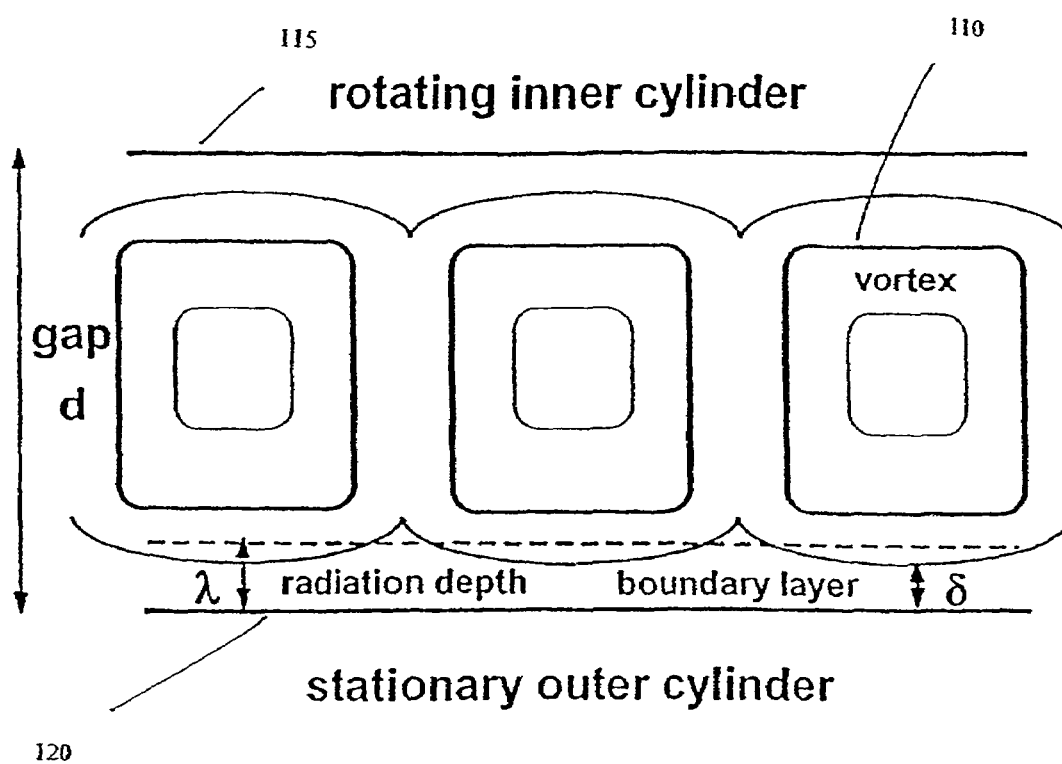


Figure 1B

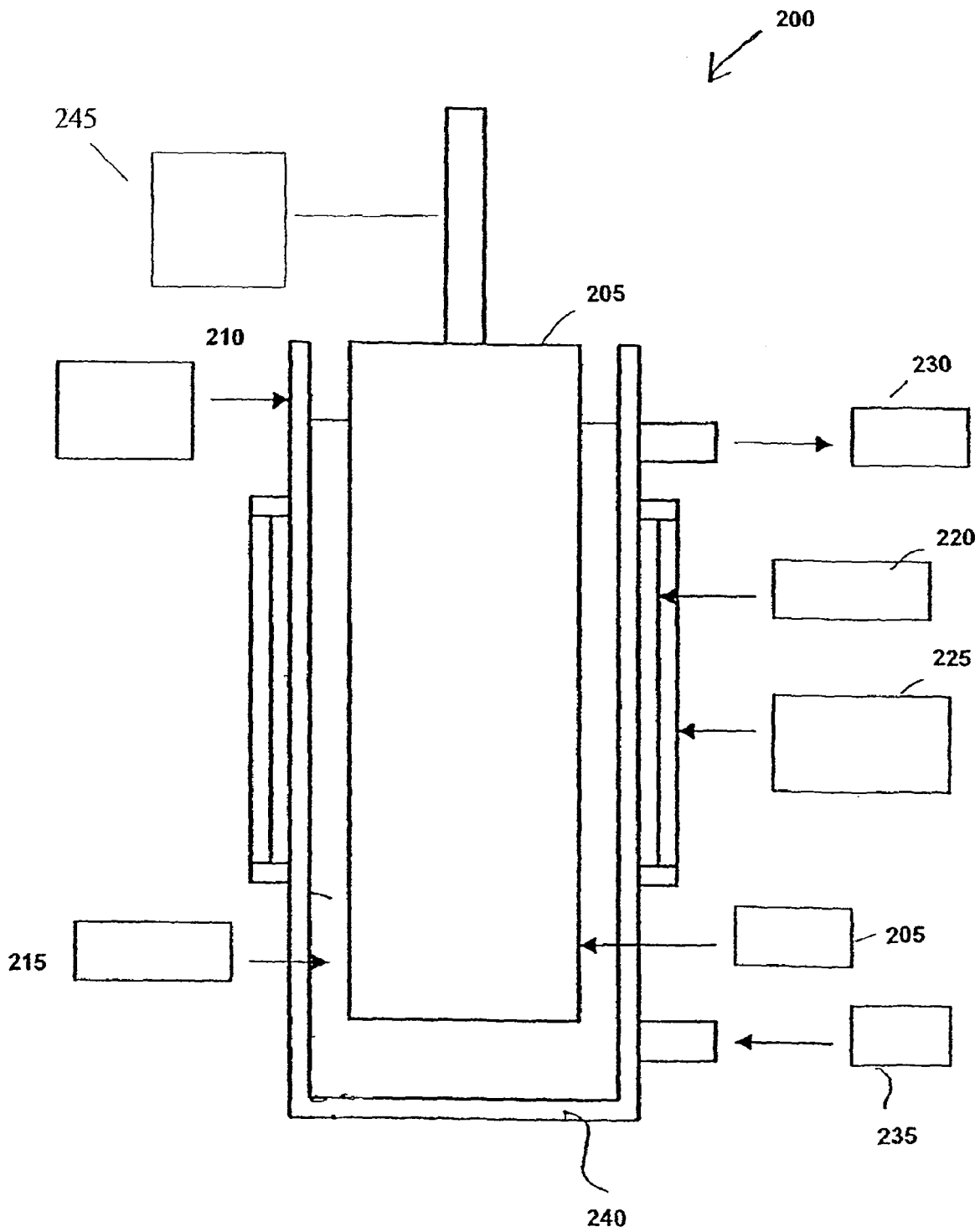


Figure 2

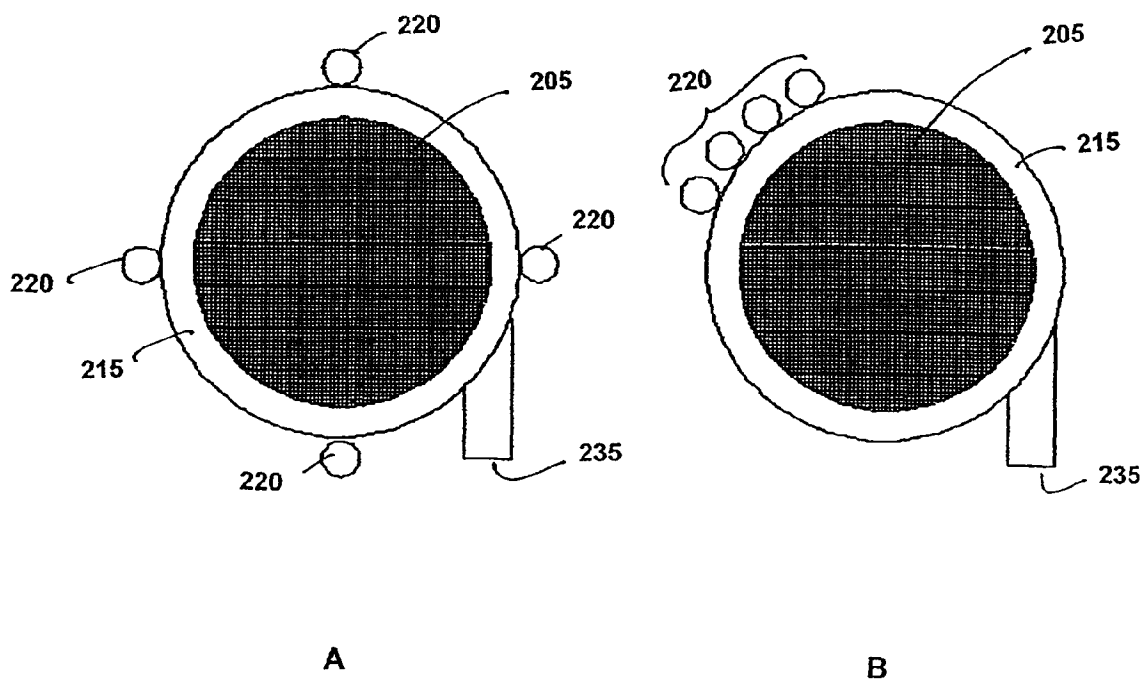


Figure 3

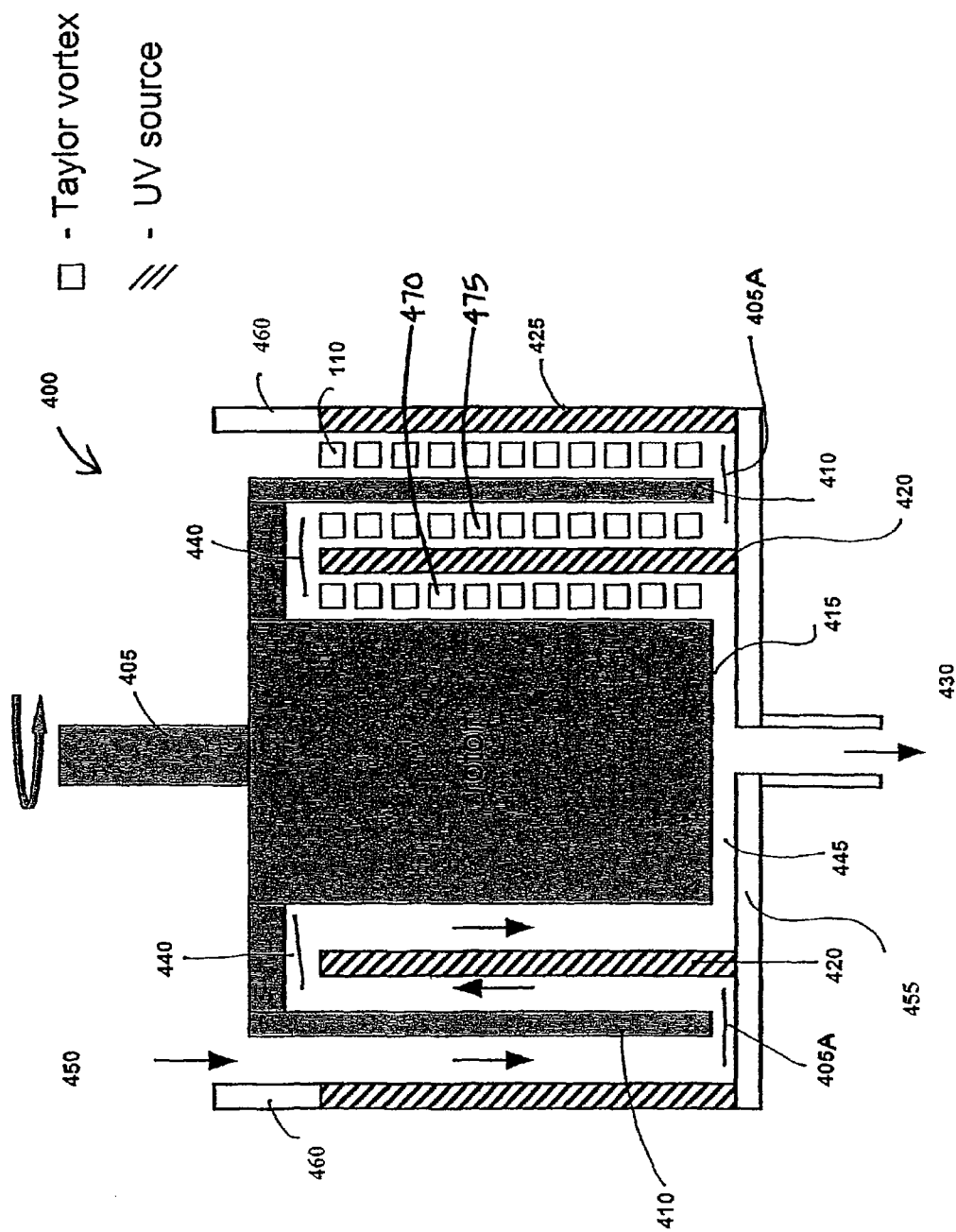


Figure 4

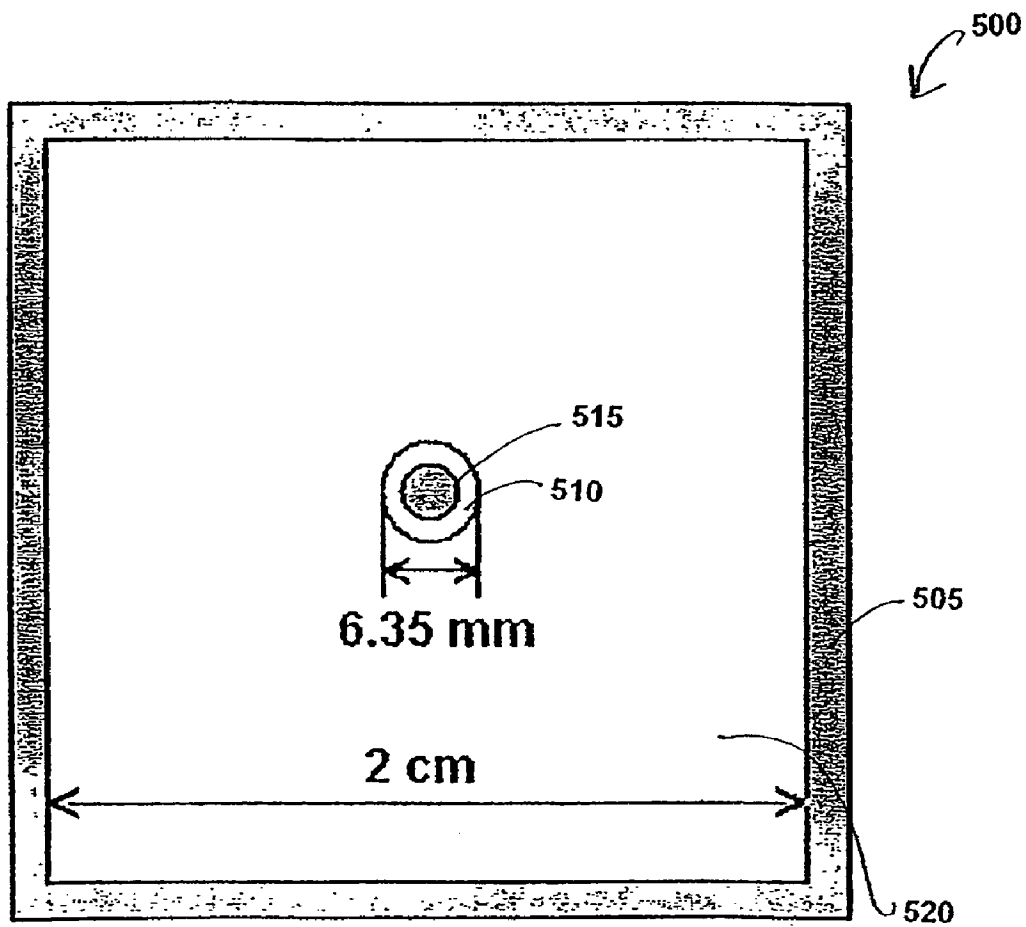


Figure 5

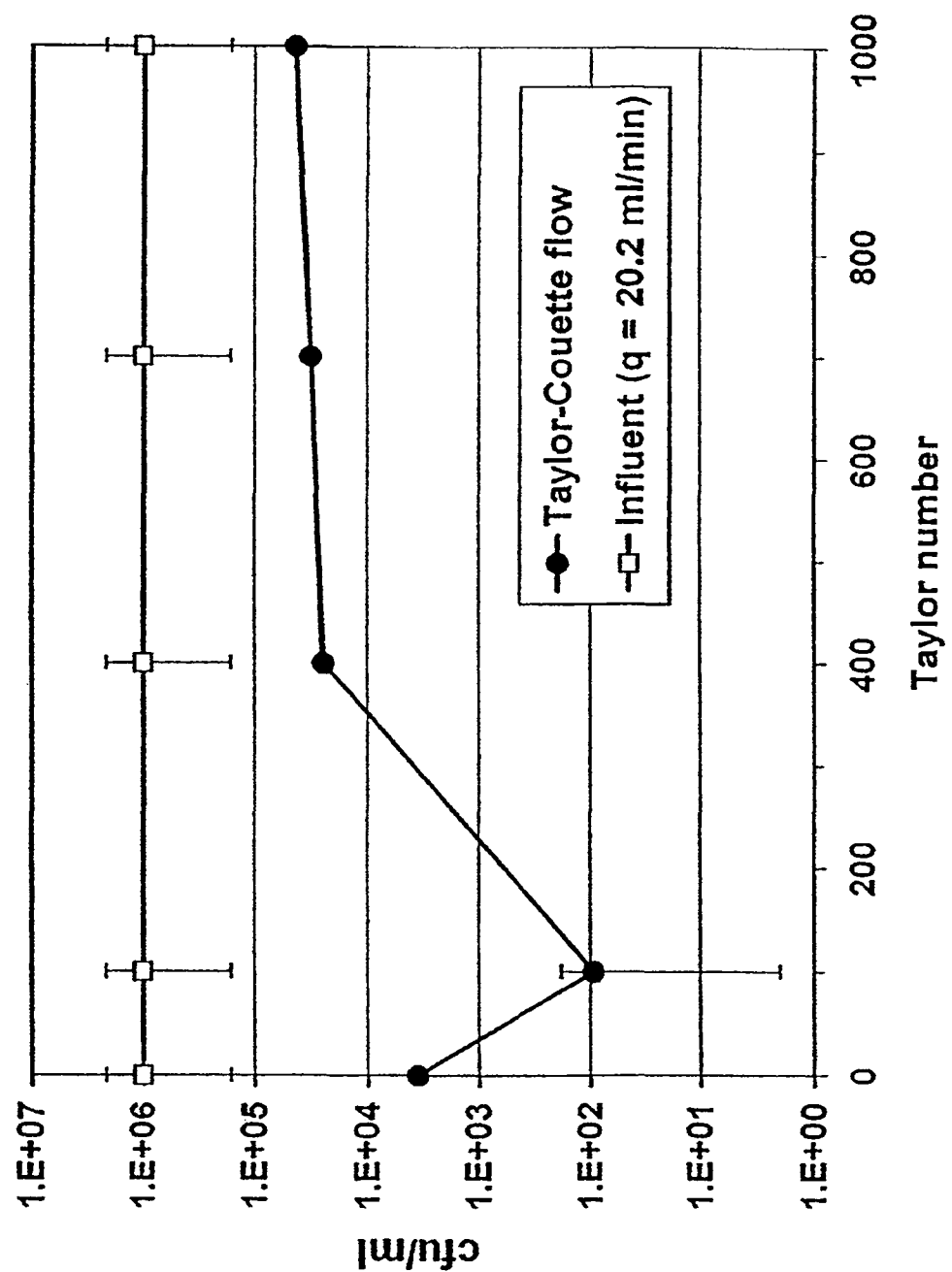


Figure 6

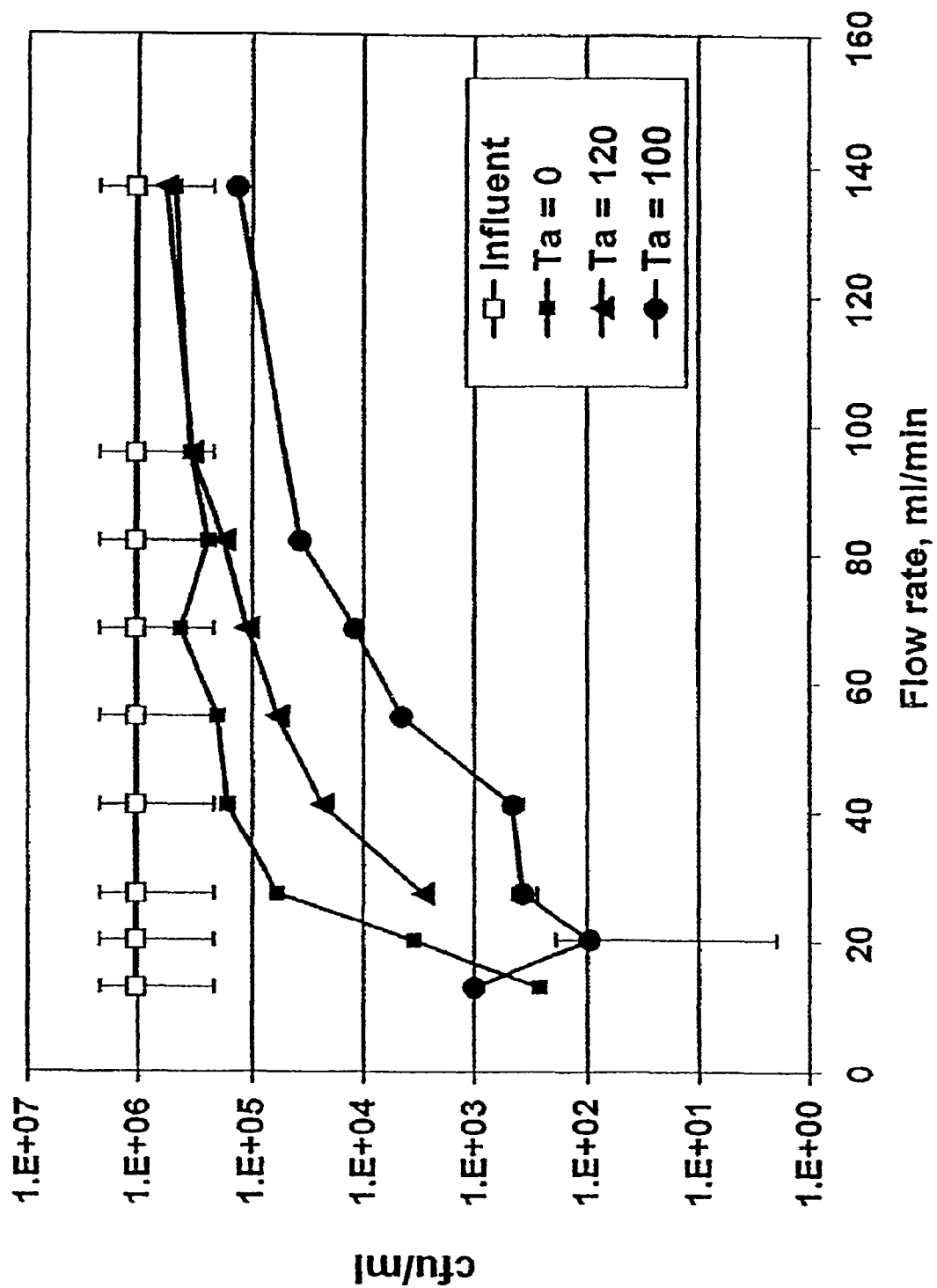


Figure 7

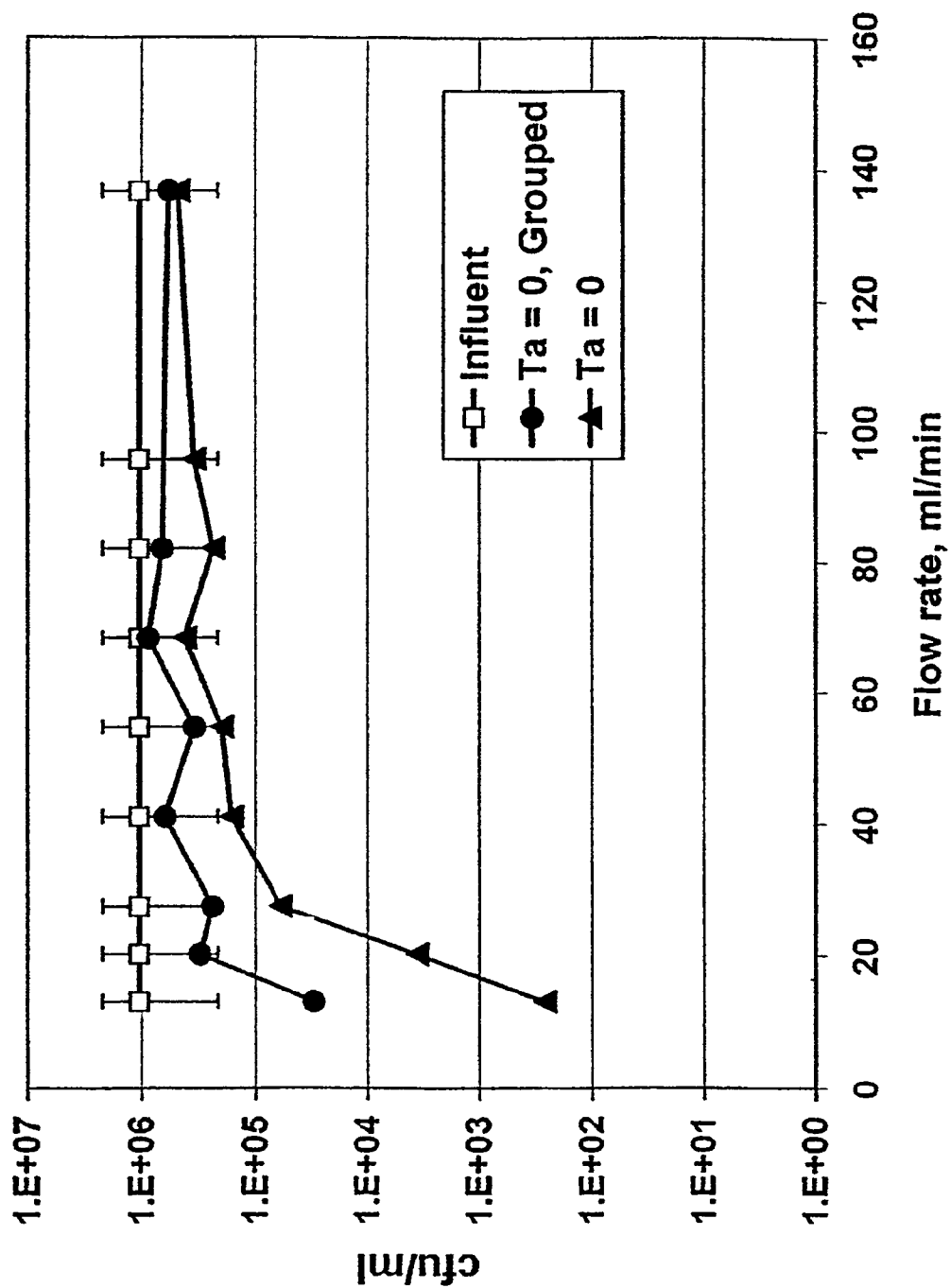


Figure 8

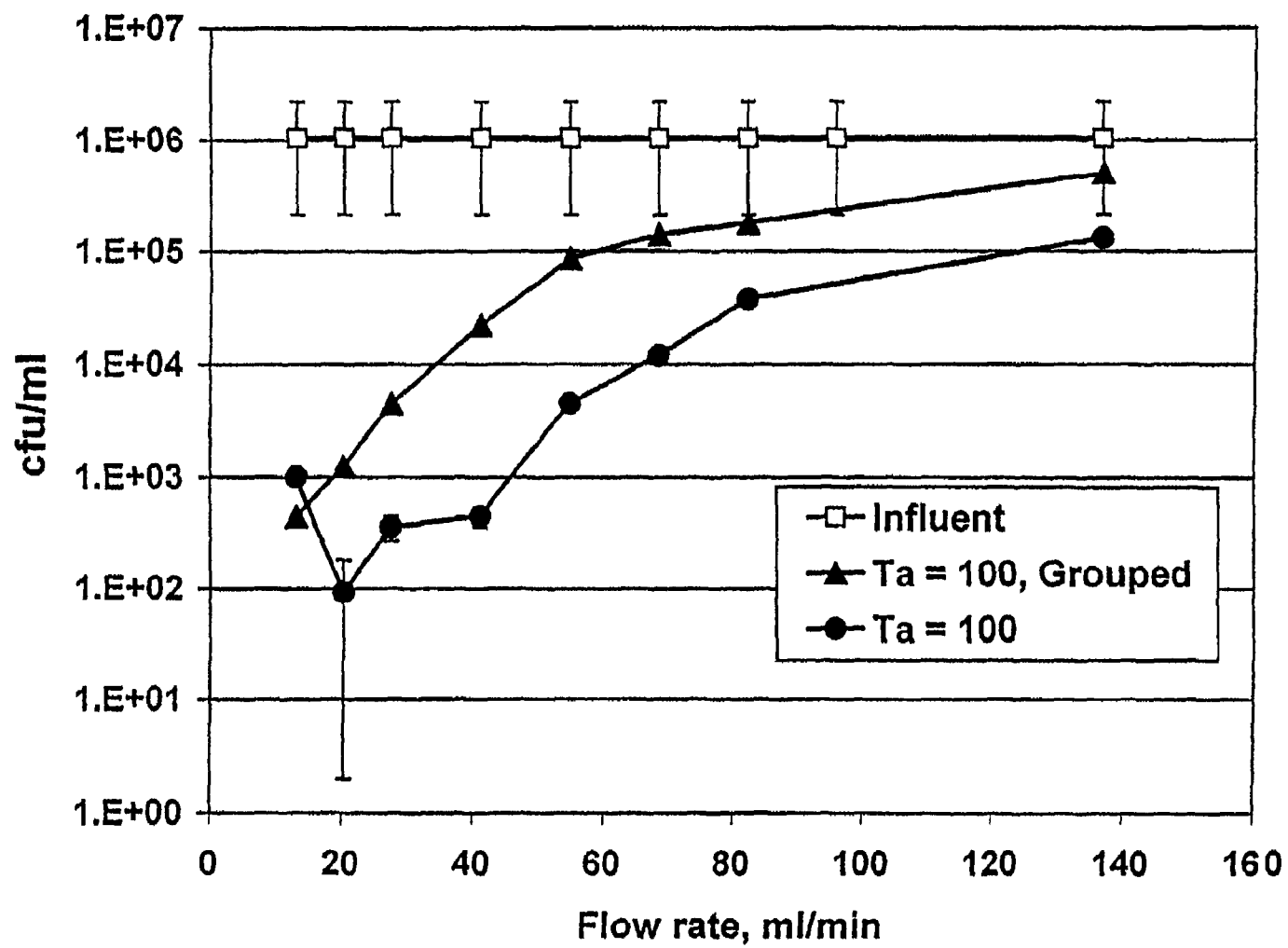


Figure 9

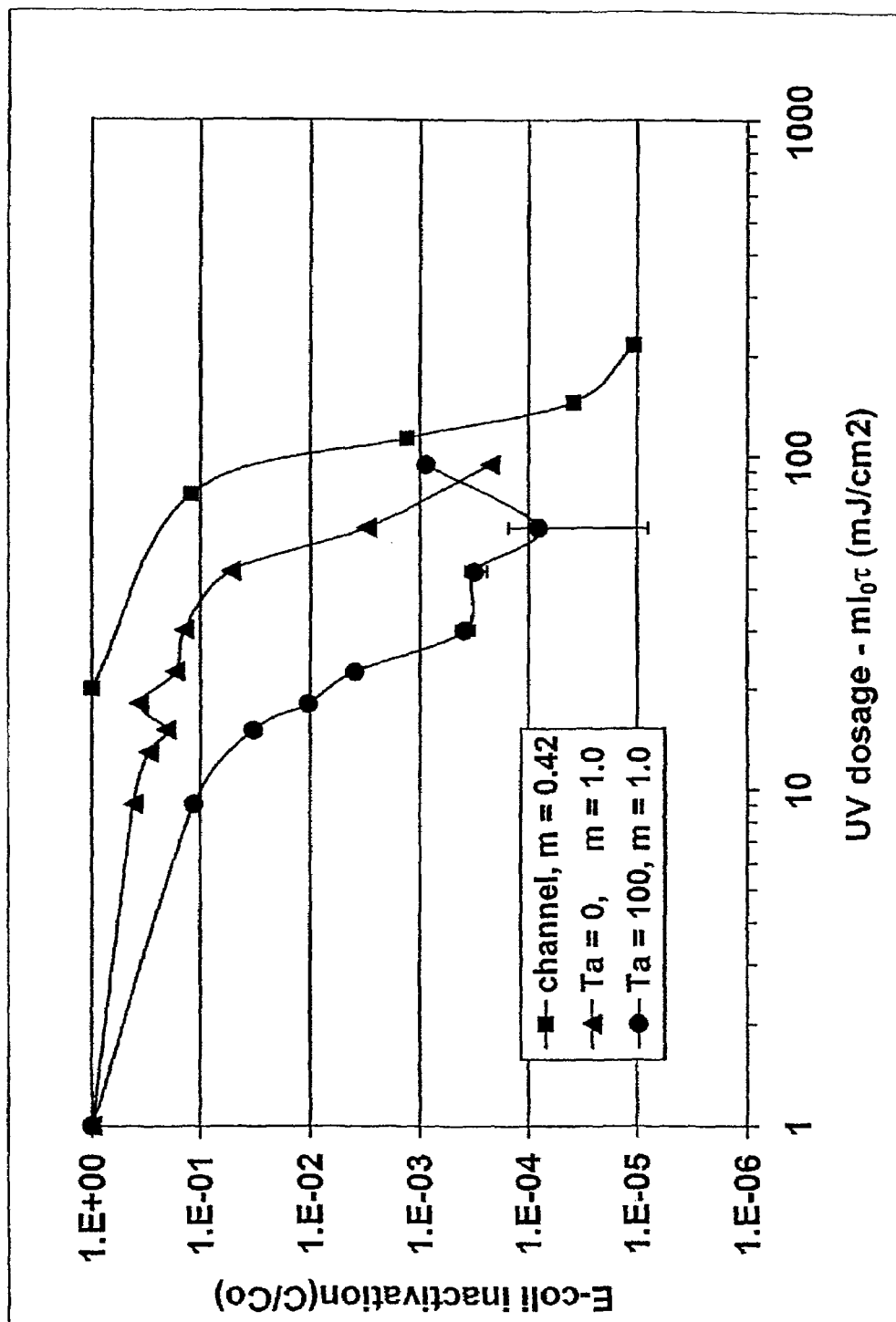


Figure 10

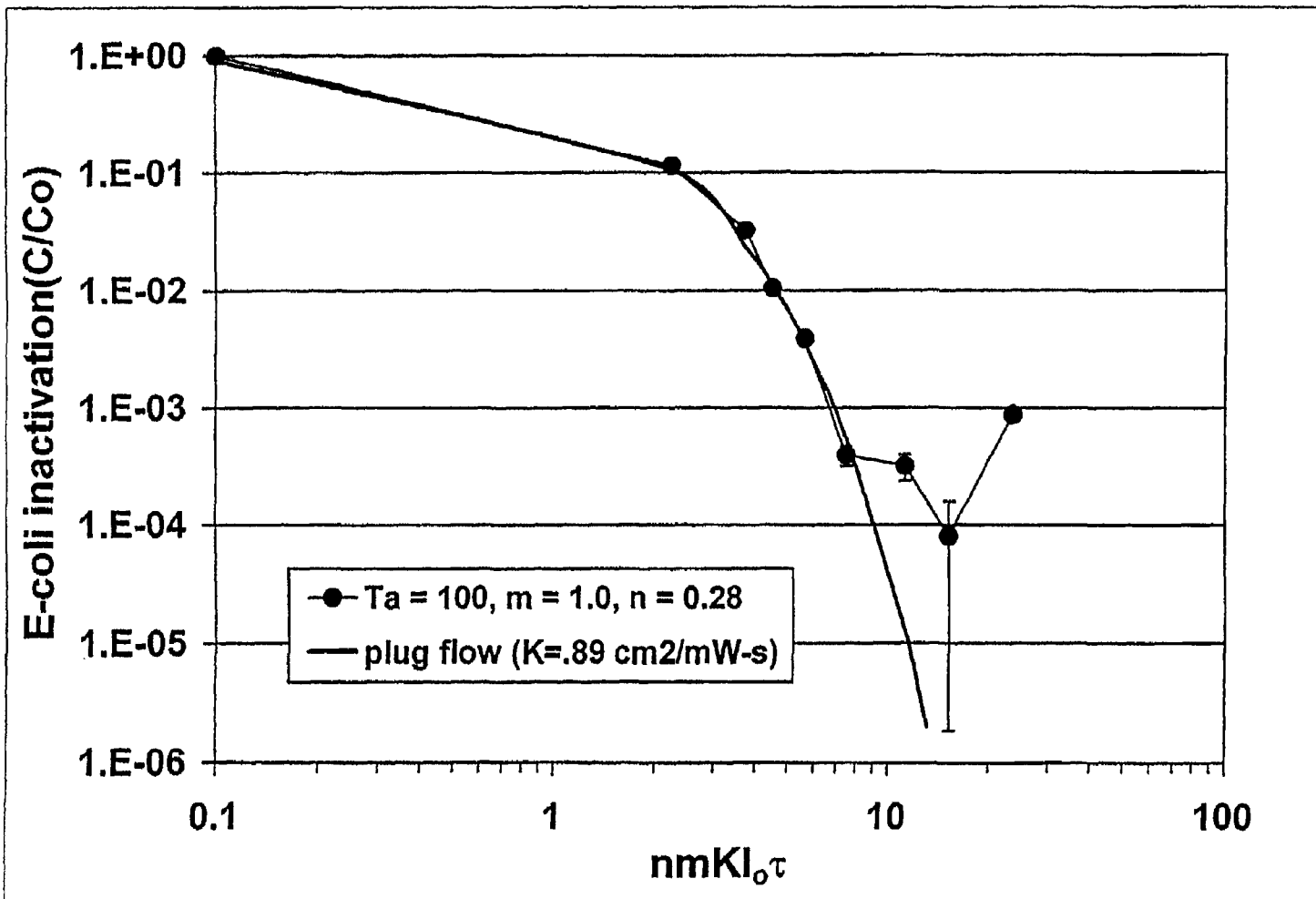


Figure 11

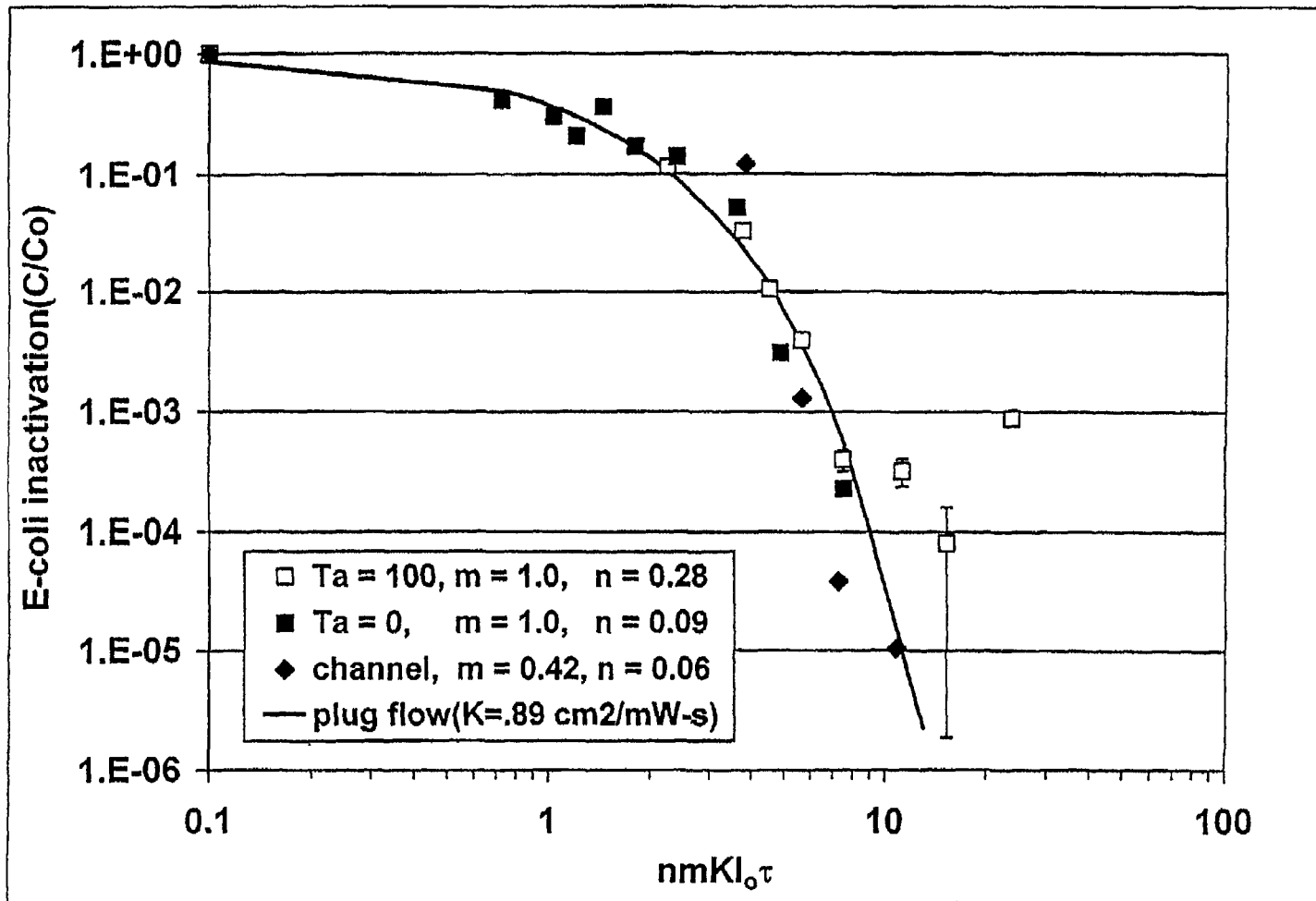
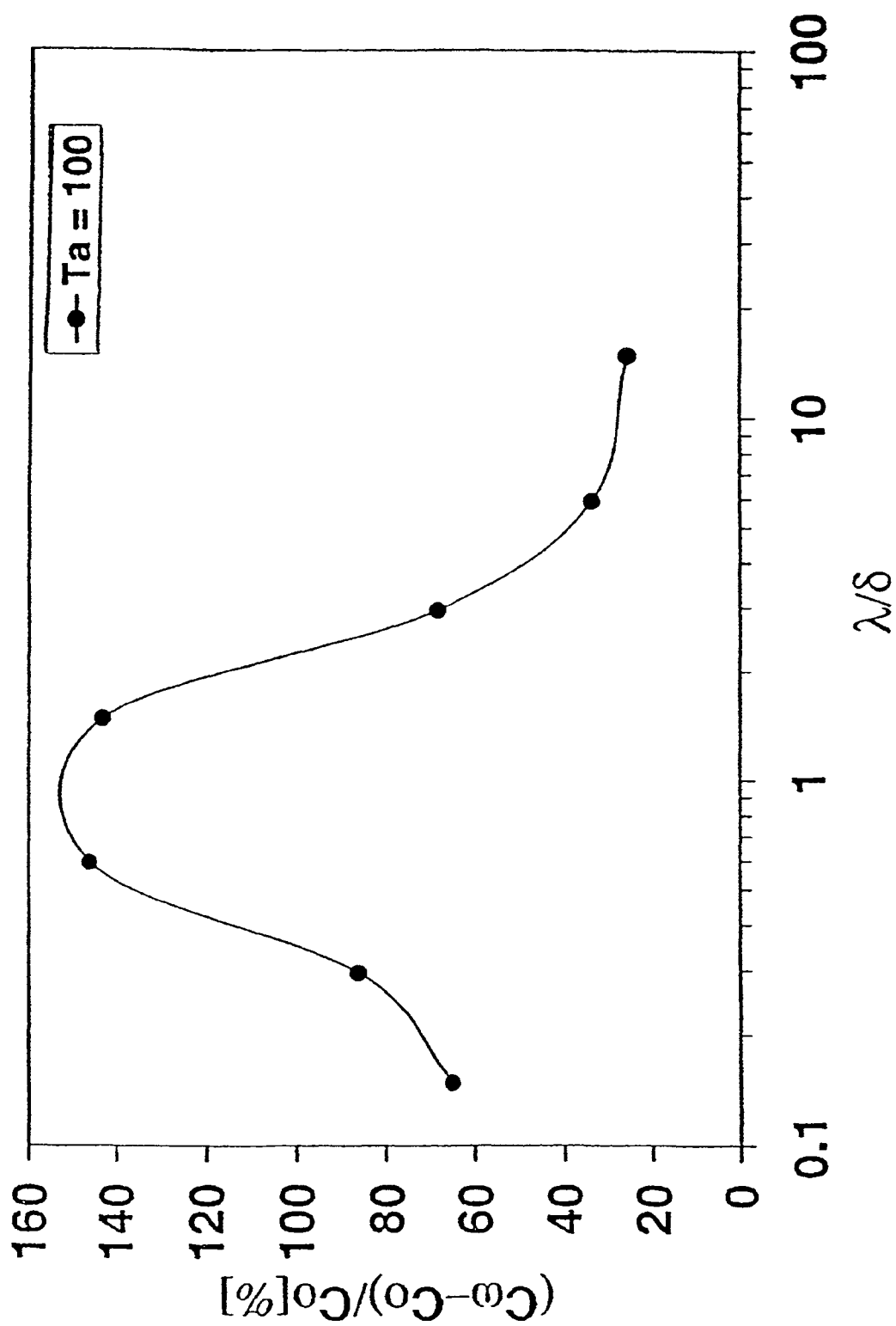


Figure 12

Figure 13



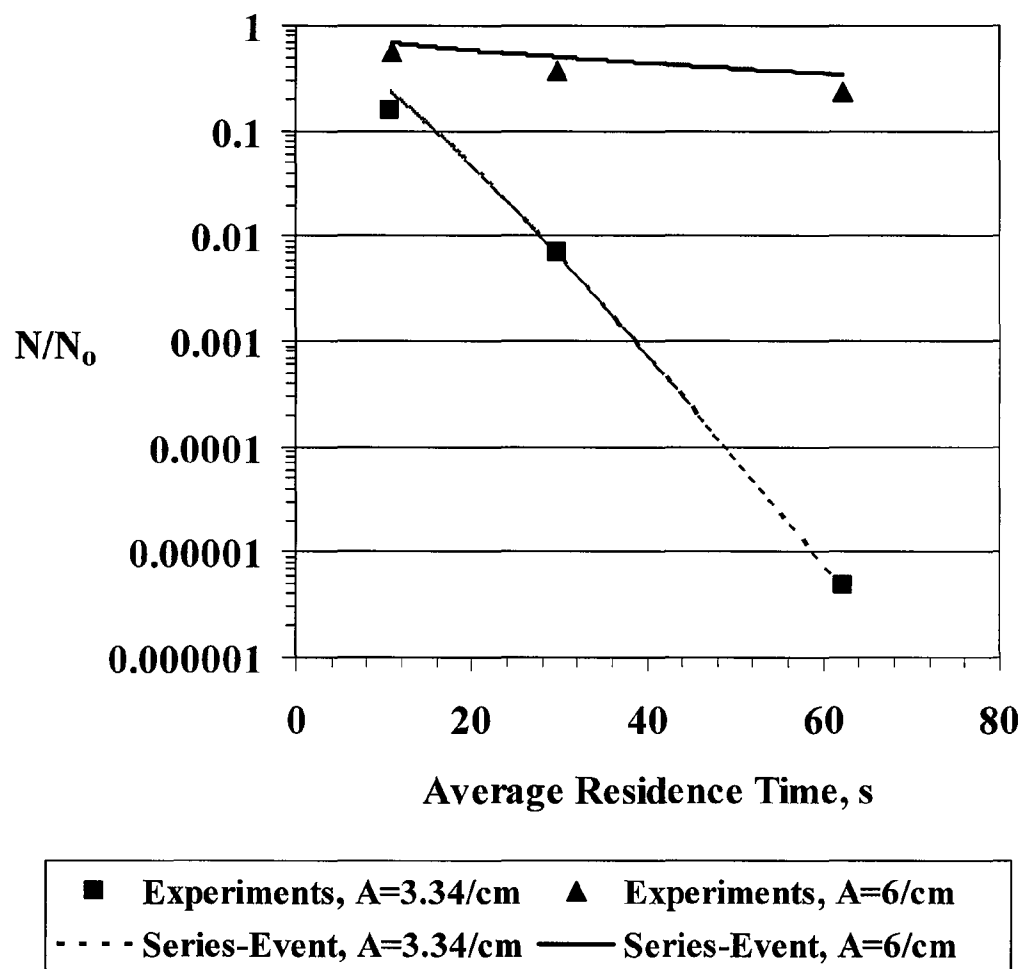
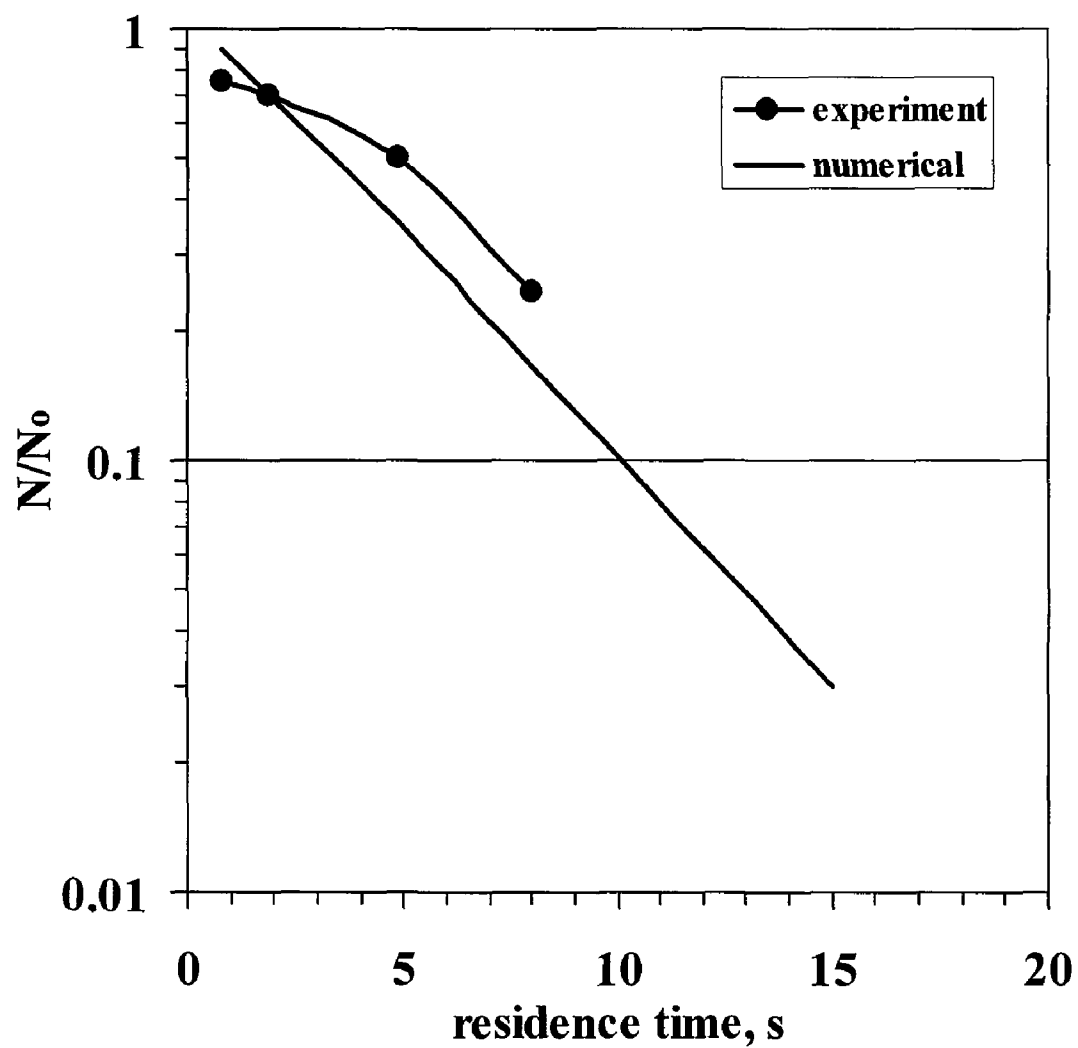
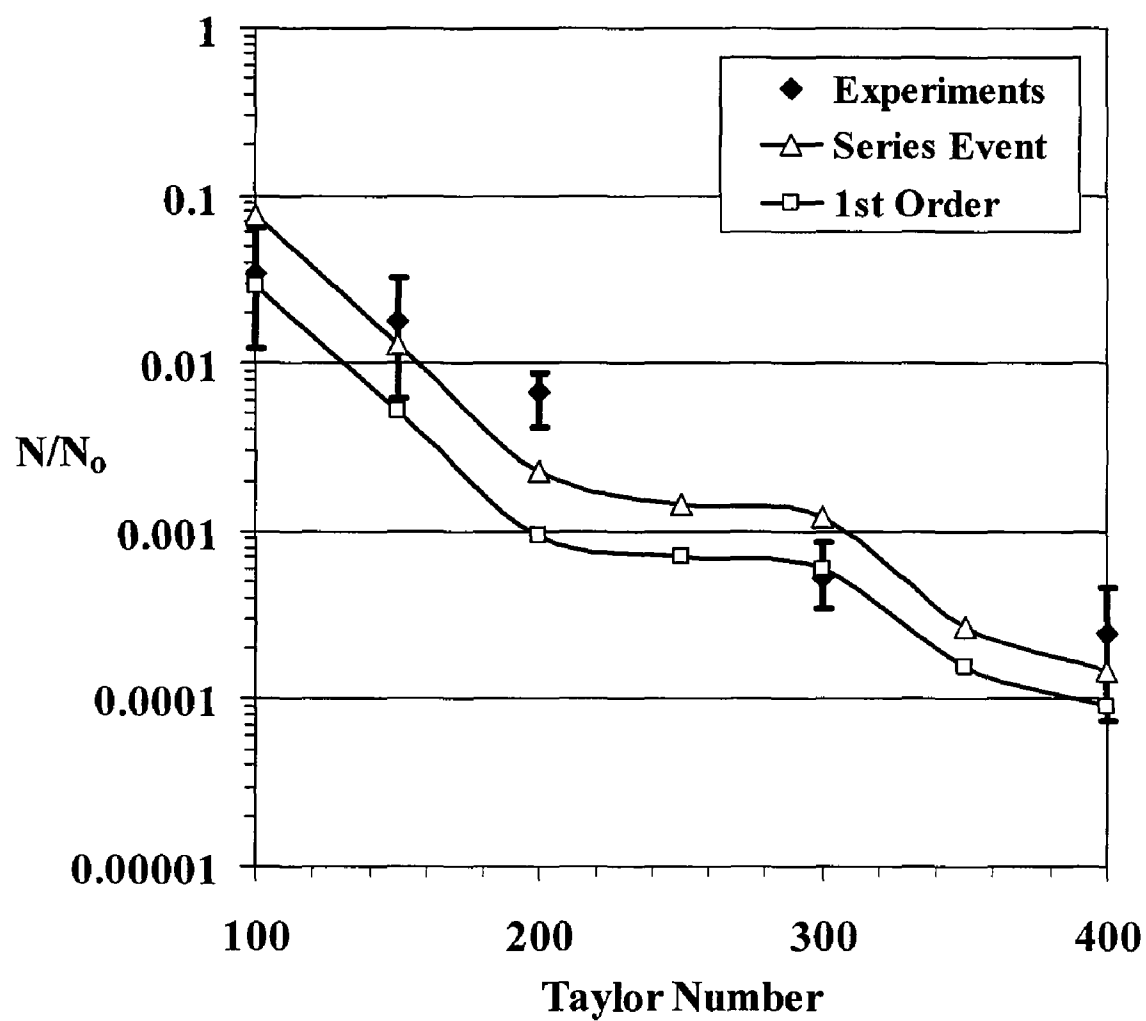
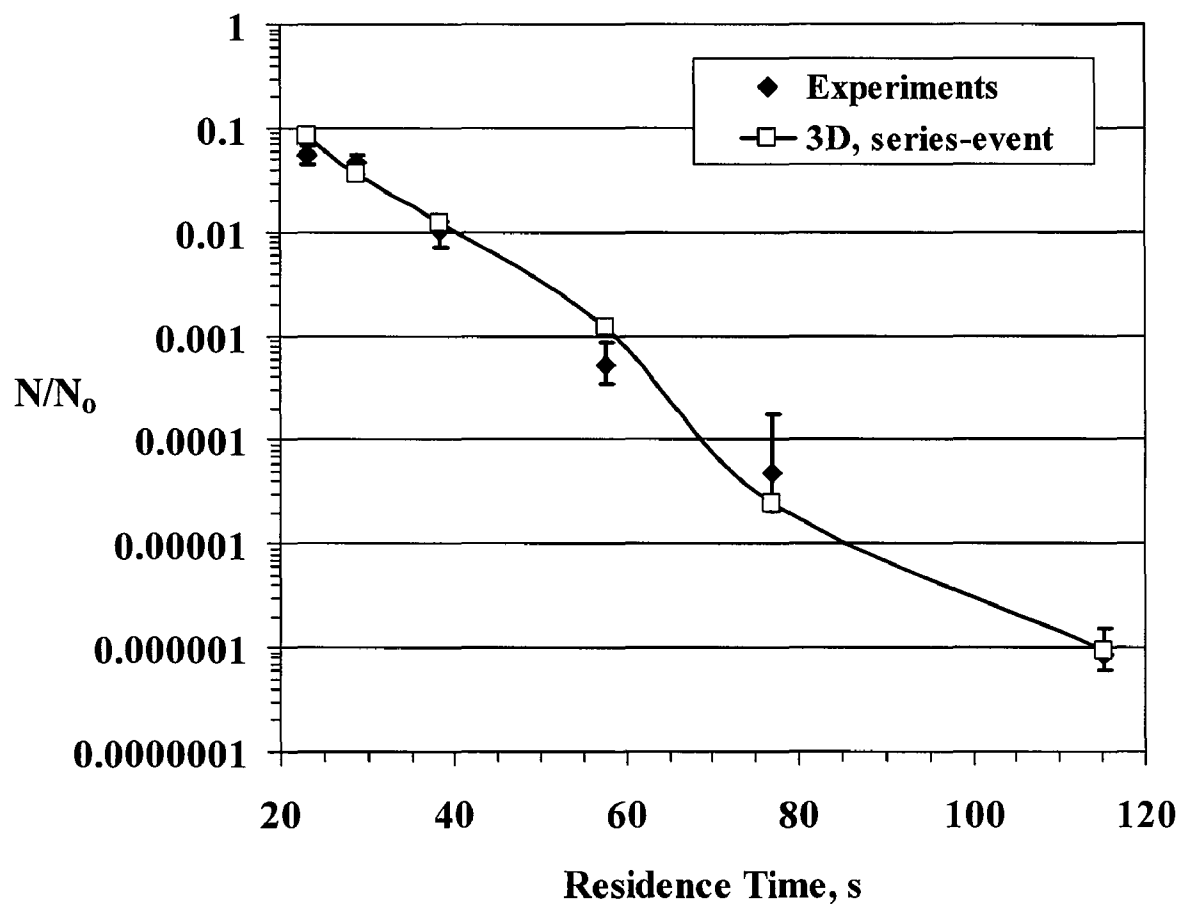
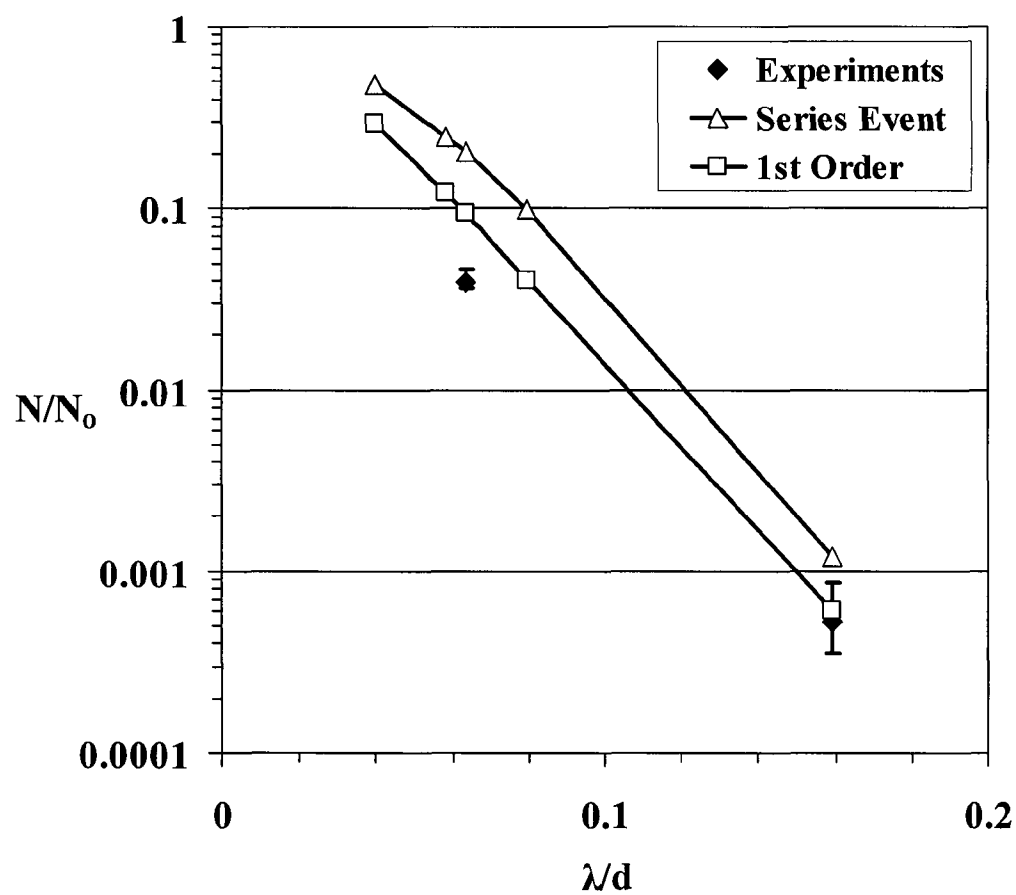


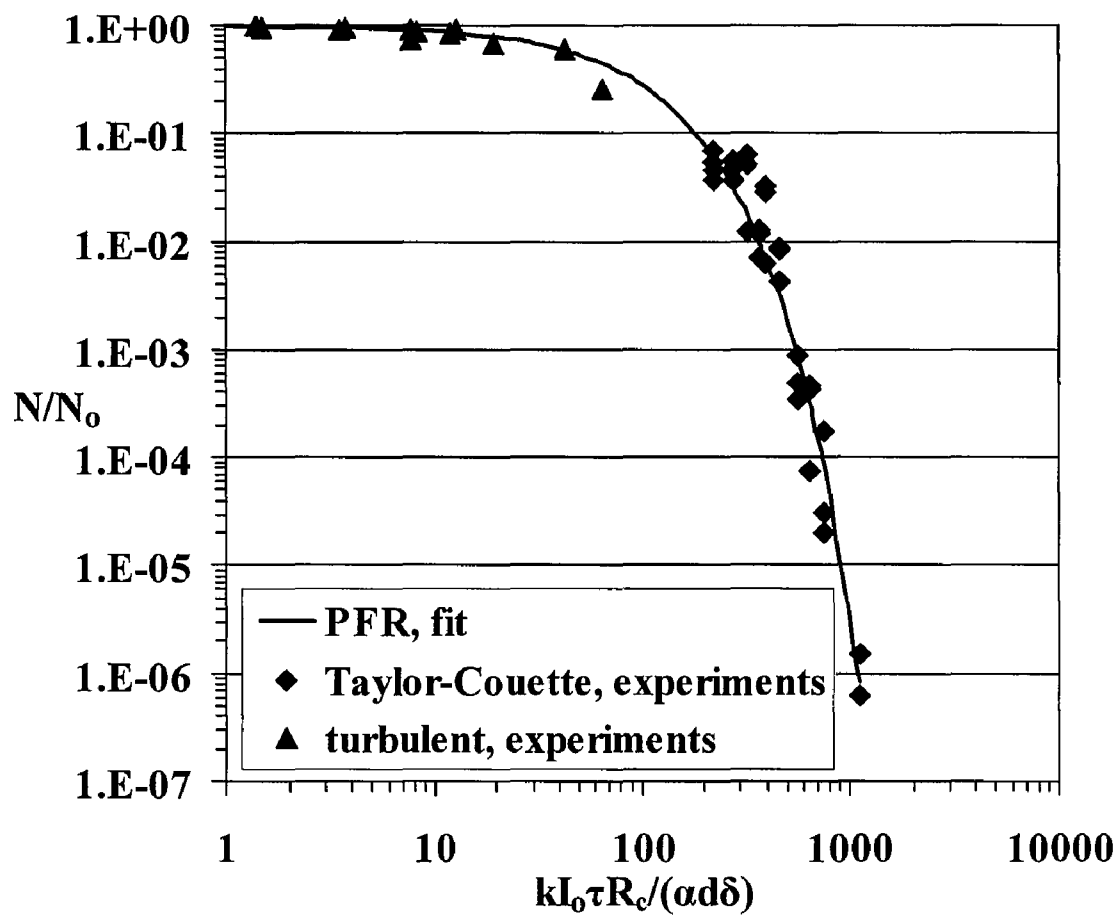
Figure 14

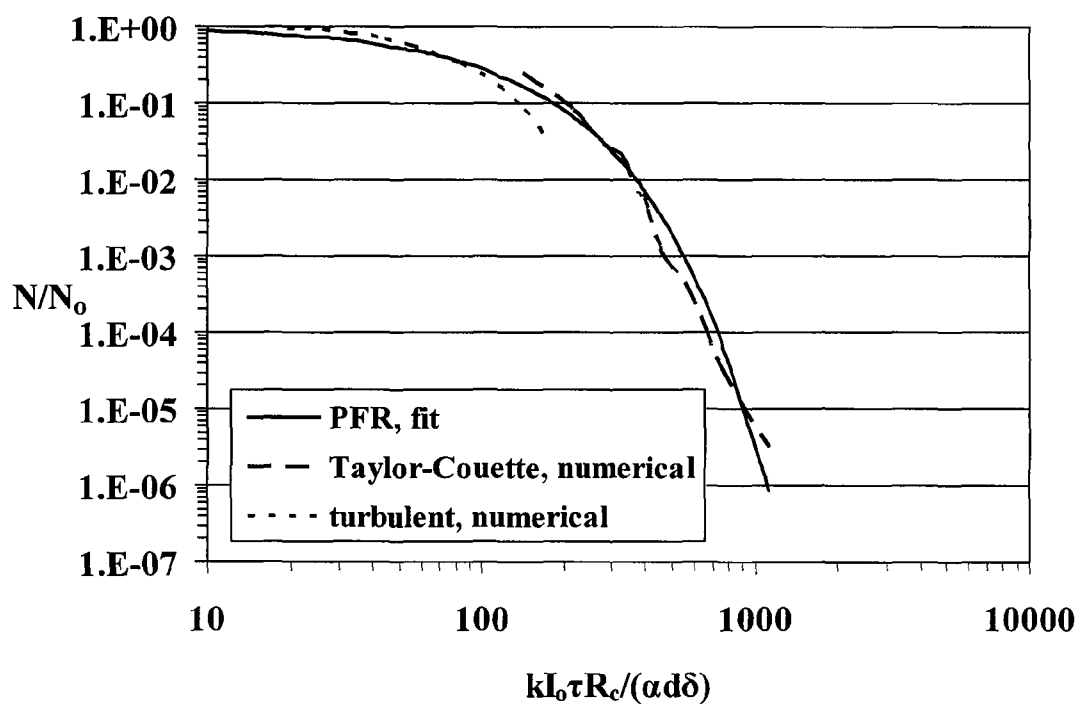
**Figure 15**

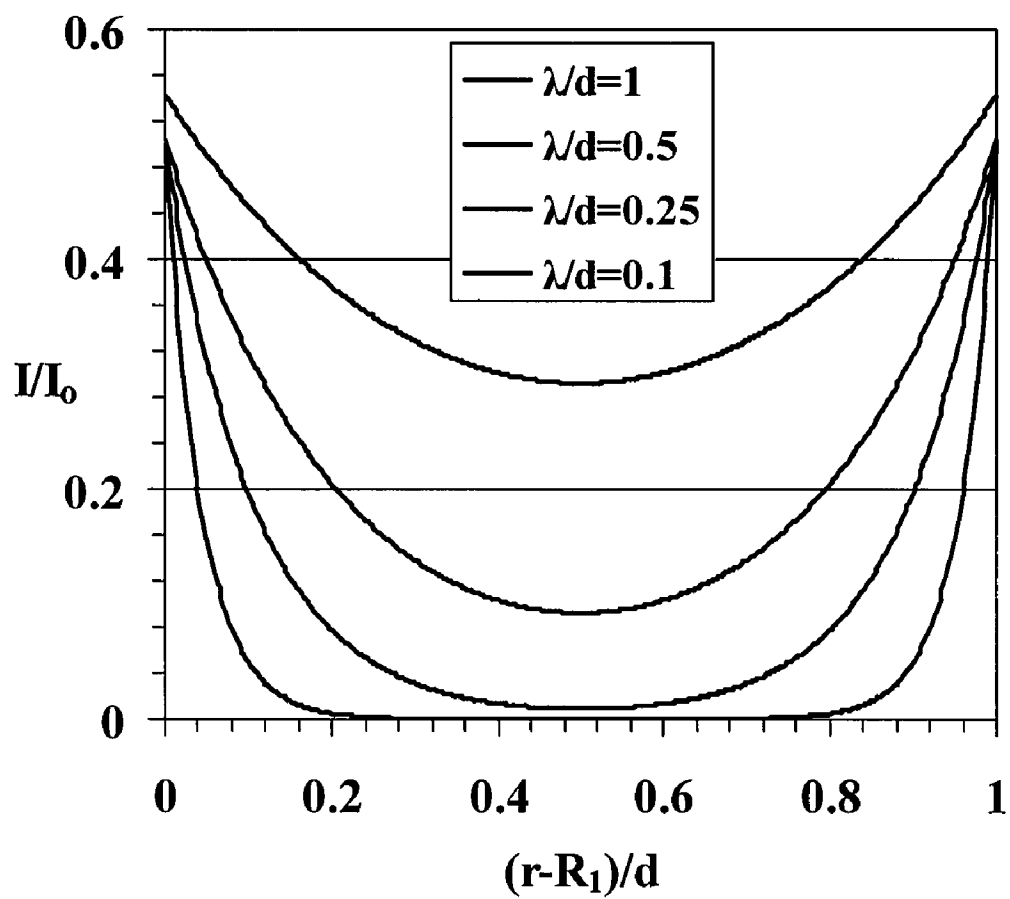
**Figure 16**

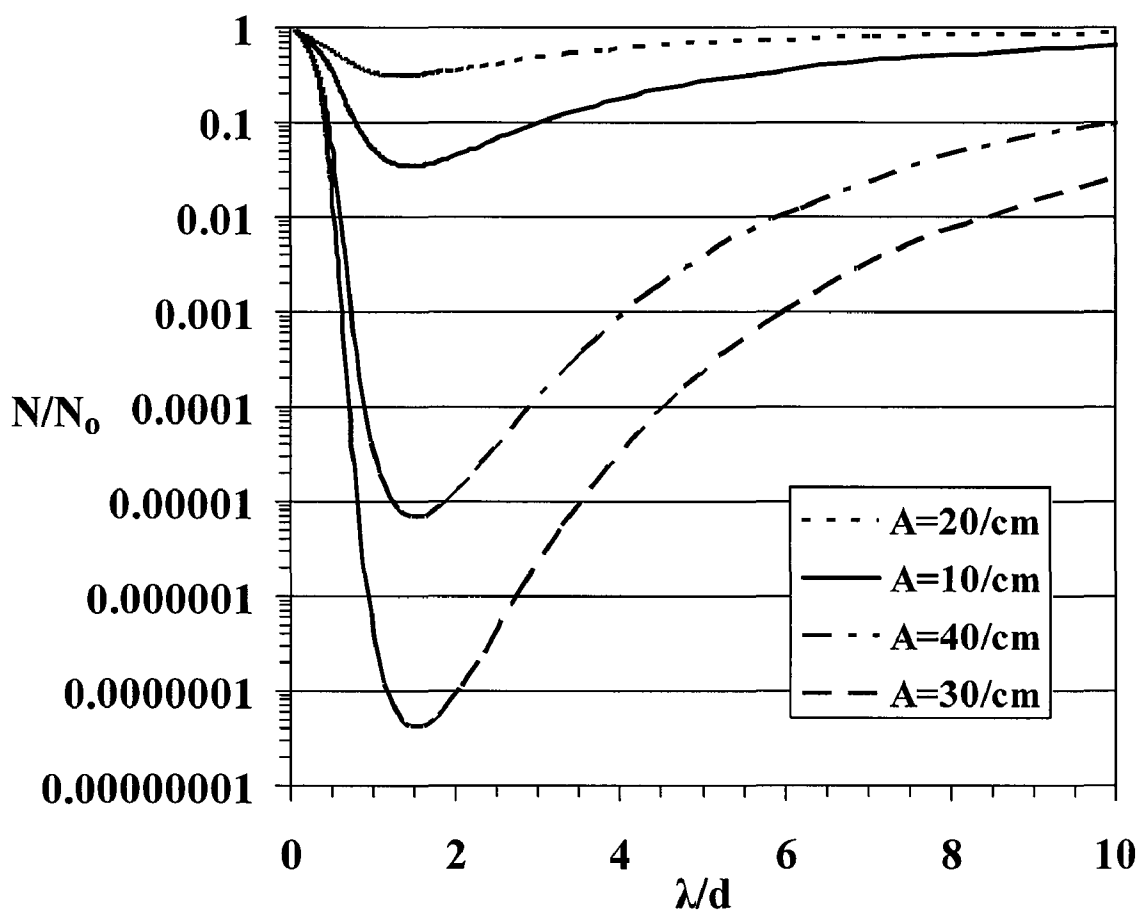
**Figure 17**

**Figure 18**

**Figure 19**

**Figure 20**

**Figure 21**

**Figure 22**

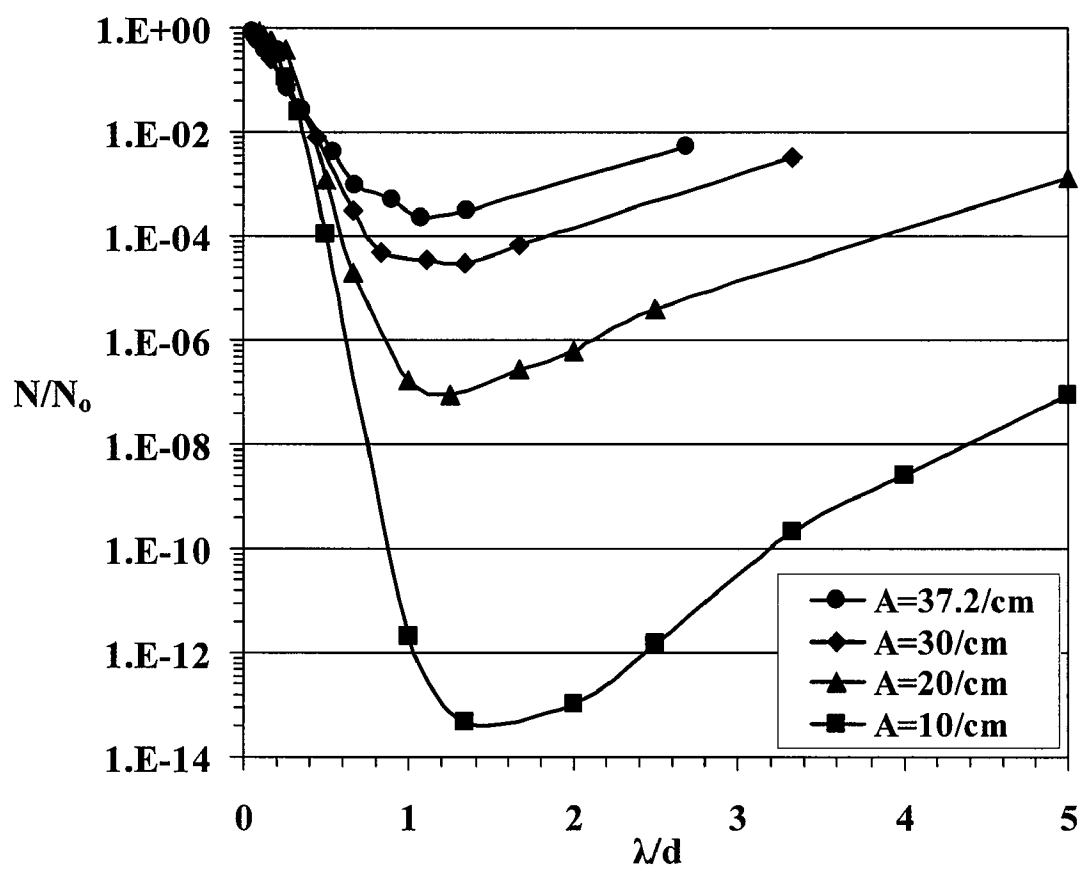


Figure 23

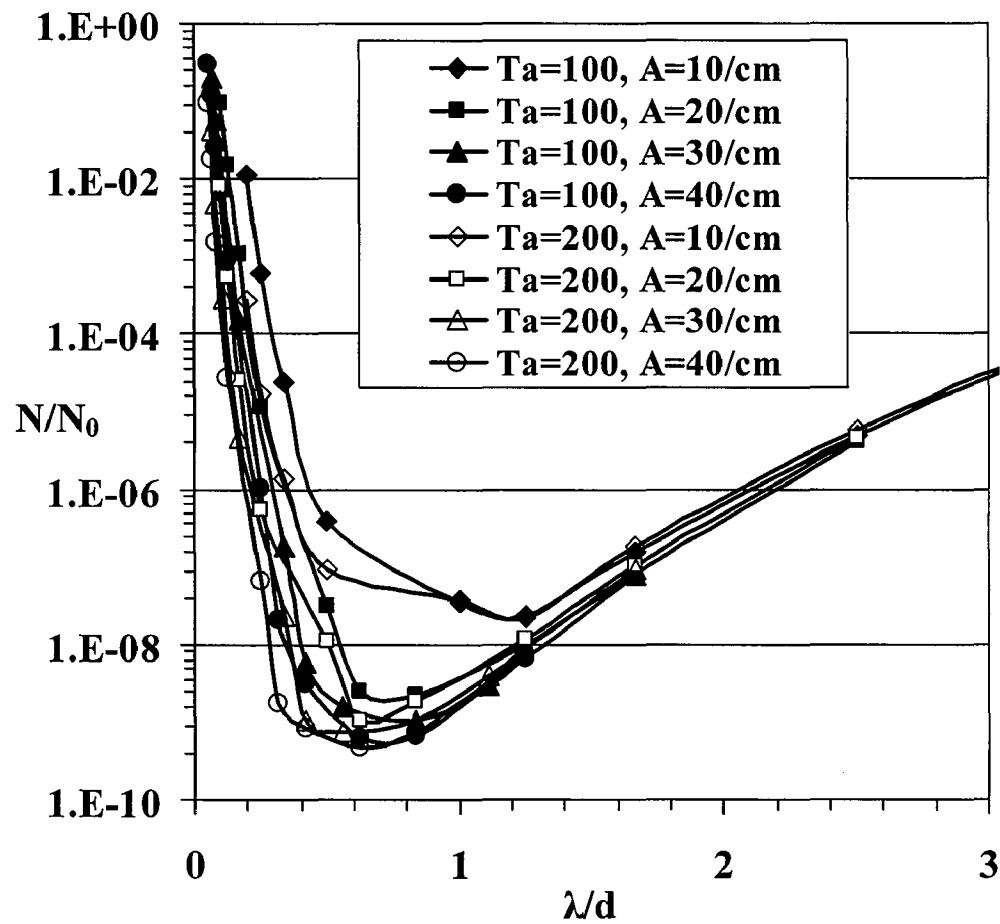
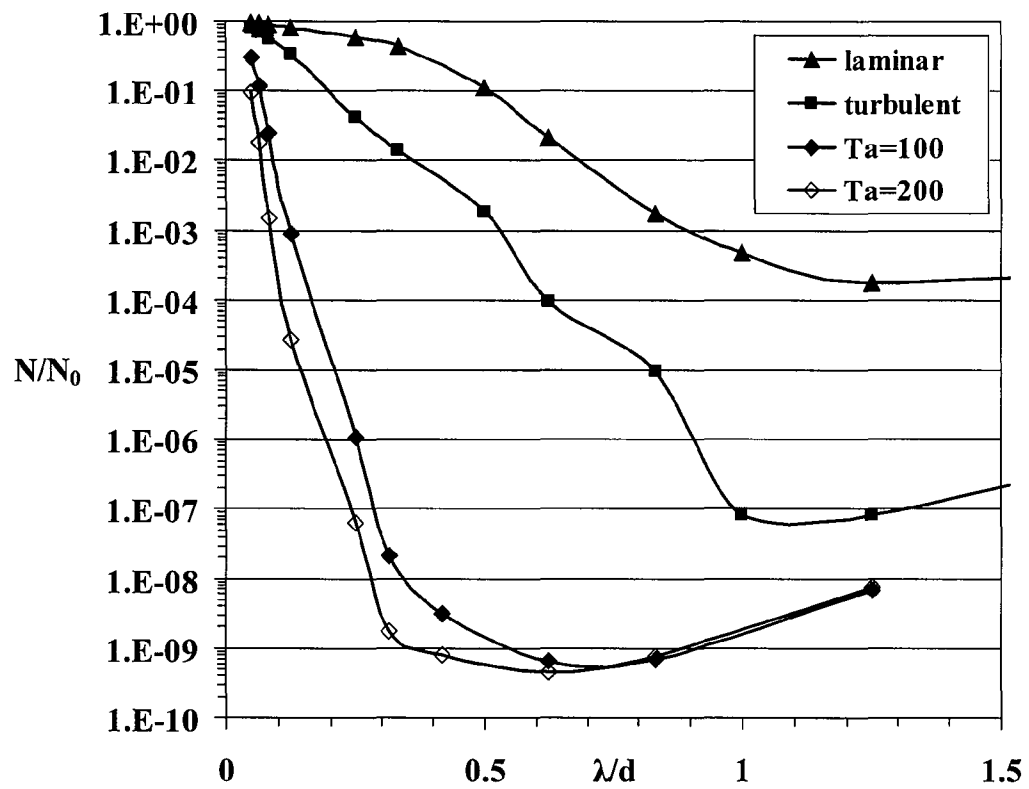


Figure 24

**Figure 25**

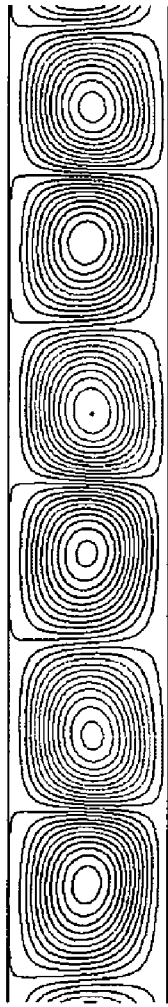
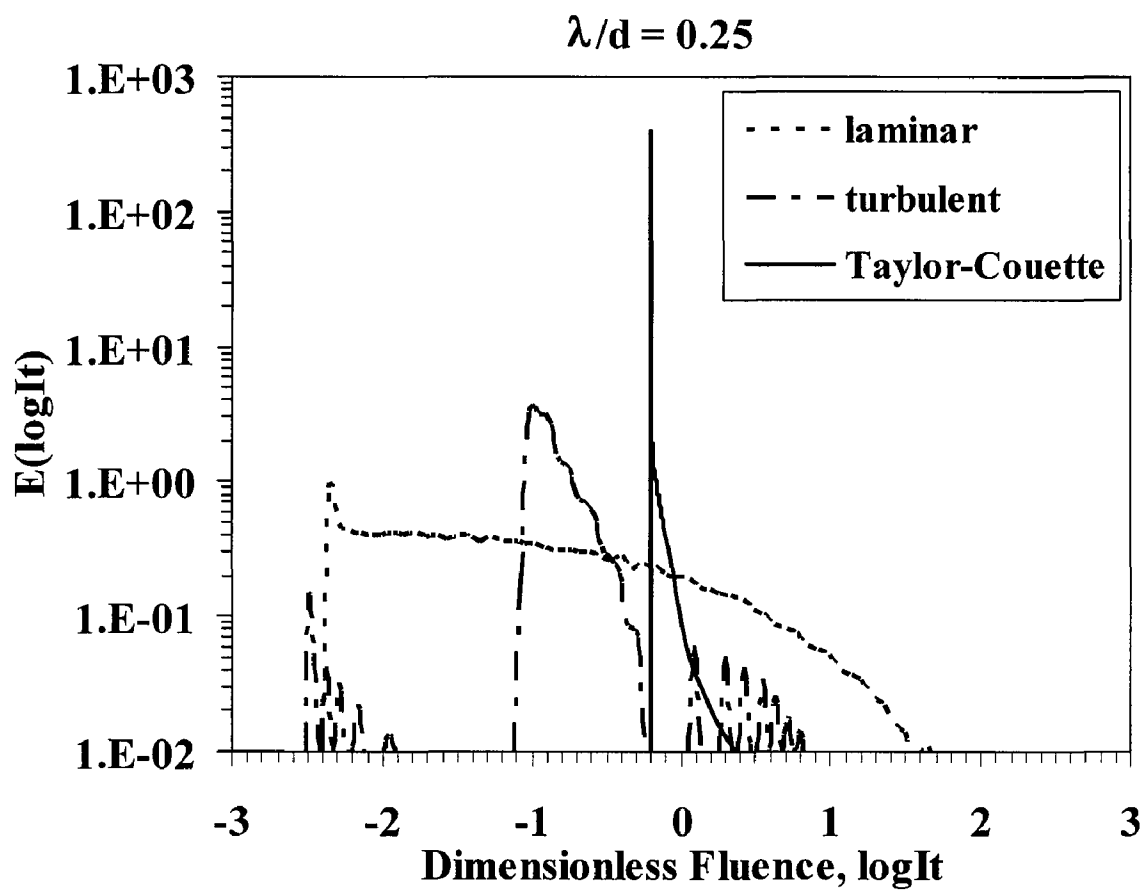


Figure 26

**Figure 27**

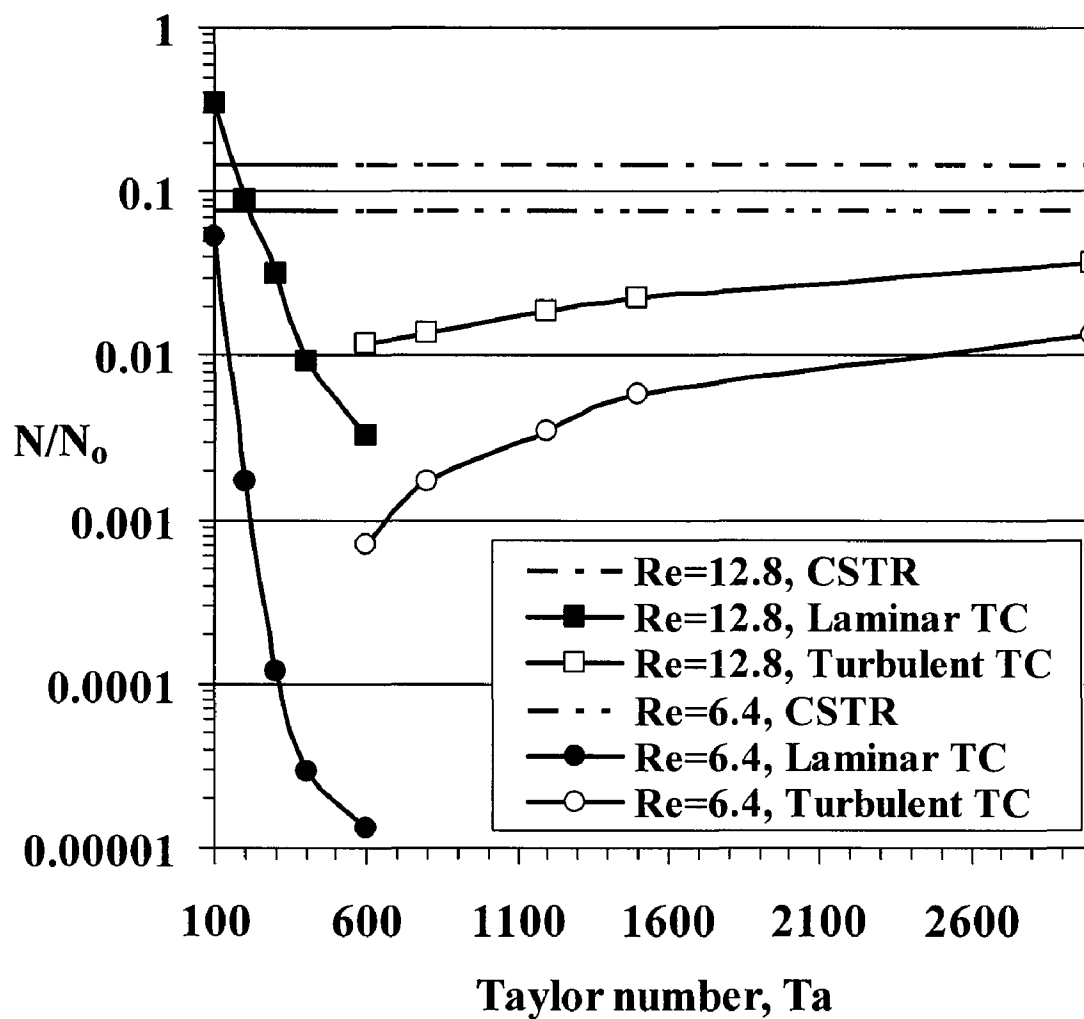


Figure 28

SYSTEMS AND METHODS FOR DISINFECTION

CROSS REFERENCE TO RELATED APPLICATIONS

This application is a continuation-in-part of U.S. application Ser. No. 11/359,005, now U.S. Pat. No. 7,507,370, filed Feb. 21, 2006, which is a continuation-in-part of U.S. application Ser. No. 10/692,983, filed Oct. 24, 2003, now U.S. Pat. No. 7,001,571, that claims the benefit of U.S. Provisional Patent Application No. 60/420,985 filed on Oct. 24, 2002, and to U.S. Provisional Patent Application No. 60/461,326 filed on Apr. 8, 2003, all of which are incorporated herein by reference in their entirety. This application also claims priority to and the benefit of U.S. Provisional Patent Application No. 60/974,891, filed Sep. 25, 2007, which is also incorporated herein by reference in its entirety.

BACKGROUND

1. Technical Field

The present disclosure is related generally to methods and systems for moving fluids, more particularly, methods and systems for generating fluid flow that increases fluid exposure to an energy source for sterilization or disinfection.

2. Related Art

Water use is a major environmental concern and methods to reduce and reuse water consumption are in demand. In food processing facilities, water shortages have made water reclamation and reuse an integral component of environmental programs. To ensure that re-used effluents do not pose an unreasonable risk to public health, the Environmental Protection Agency (EPA) has outlined strict regulations for water reclamation. These water disinfection regulations provide a substantial public health benefit by reducing discharges of many waterborne pathogenic organisms to water supplies, recreational water, shellfish water and other waters that can potentially transmit disease to humans.

Many technologies exist for bacterial destruction in water reclamation such as chlorination which is a relatively low cost disinfection process. Chlorine treatment, however, presents a number of problems. For example, chlorine disinfection is incapable of achieving appreciable inactivation of the several viruses and protozoa, specifically, *Cryptosporidium parvum* at reasonable disinfectant doses and contact times (Sobsey, M. D. (1989). *Inactivation of health-related microorganisms in water by disinfection processes*. Wat. Sci. Tech. 21:179-195). In addition, large chlorine concentrations generate chloro-organic, disinfection by-products such as trihalomethanes (THMs) and other carcinogens that persist in the environment (Matsunaga, T., and M. Kkochi. (1995). *TiO₂-Mediated Photochemical Disinfection of Escherichia coli Using Optical Fiber*. Environ. Sci. Technol. 29:501-505).

Due to the environmental concerns associated with chemical disinfection, current water treatment methods are moving away from traditional chemical to physical procedures (Cho, I. H. et al. (2002). *Disinfection effects E. coli using TiO₂ A/V and solar light system*. Wat. Sci. and Tech. 2: 181-190). For example, use of ultraviolet (UV) radiation is becoming more popular for wastewater treatment since it is effective against both bacteria and viruses, leaves no residues and is economical (Wong, E. et al. (1998). *Reduction of Escherichia coli and Salmonella senftenberg on pork skin and pork muscle using ultraviolet light*. Food Microbiology. 15:415-423). UV processing uses radiation in the germicidal range from 200 to 280 nm to generate DNA mutations within pathogens (Federal

Department of Agriculture and Center for Food Safety and Applied Nutrition. (2000). *Kinetics of microbial inactivation for alternative food processing technologies: Ultra-violet light*). The latter study also concludes that to achieve microbial inactivation, the UV radiant exposure must be at least 400 J/m² in all parts of the product. Moreover, UV irradiation is particularly effective when it is used in conjunction with powerful oxidizing agents such as ozone and hydrogen peroxide.

Treatment of fluid flow is also important in food processing for example in processing of beverages such as milk, juices, alcoholic drinks or soft drinks. Existing methods for treating fluid foodstuffs typically include exposing the foodstuffs to high temperatures in an effort to neutralize potentially harmful bacteria. Unfortunately, thermal treatment of foodstuff can cause the breakdown of ingredients including proteins and vitamins. The United States Food and Drug Administration (US-FDA) has recently published a ruling (21 CFR 179) that approves the use of UV radiation in place of pasteurization.

Early modeling of disinfection efficiencies in flow-through UV reactors focused on the ideal designs of either a completely mixed (stirred tank) or plug flow configurations (Haas, C. N. and Sakellaropoulos, G. P. (1979). *Rational analysis of ultraviolet disinfection reactors*, Proceedings of the National Conference on Environmental Engineering, American Society of Civil Engineering, Washington, D.C.; Severin, B. F. et al. (1984) *Kinetic modeling of UV disinfection of water. Inactivation kinetics in a flow-through UV reactor*, J WPCF. 56:164-169). As summarized by the Water Environment Federation (Water Environment Federation (1996). *Wastewater Disinfection Manual of Practice FD-10*, chapter 7, Alexander, V A.), Scheible (Scheible, O. K. (1987). *Development of a rationally based design protocol for the ultraviolet disinfection process*. J. Water Pollution Control Fed. 59:25-31) developed a model to account for non-ideal reactor theory that requires four empirical constants. A strictly empirical model was also proposed by Emerick and Darby (Emerick, R. W. and Darby J. L. (1993). *Ultraviolet light disinfection of secondary effluents: predicting performance based on water quality parameters*. Proc. Plann. Des. and Oper. Effluent Disinfection Syst. Spec. Conf., Water Environment Federation, Whippany, N.J., p. 187) to account for a number of factors that influence water quality. Recently, computational fluid dynamic (CFD) solutions have provided insight into the turbulent flow characteristics of UV reactors (Lyn, D. A. et al. in E.R. (1999). *Numerical Modeling of flow and disinfection in UV disinfection channels*, J Environ. Eng. 125, 17-26).

Of the two ideal designs and considering a single reaction, it is well established that plug flow provides comparable yield but with a substantial reduction in holdup volume that can exceed two orders of magnitude compared to a completely mixed reactor (Levenspiel, O. (1972). *Chemical Reaction Engineering*, 2nd Ed., John Wiley and Sons, Inc., New York, N.Y.). For such plug flow designs, the surface-to-volume ratio is large which is favorable to the transmission of UV radiation through the reactor walls and contained fluid. The major limitations to plug flow designs, however, are both non-uniform radiation intensities within the fluid and low concentrations of absorbing species such as viable pathogens near irradiated walls. The effects of the latter are reduced by increasing the flow rate thus reducing the velocity and concentration boundary layer thickness but, unfortunately, also the residence time and thus the radiation dosage.

Previous studies on the effects of radiation in Taylor-Couette flow are the growth of algae (Miller, R. L. et al. (1964).

Hydromechanical method to increase efficiency of algal photosynthesis, Ind. Engng. Chem. Process Des. Dev. 3:134) and the development of a reactor for heterogeneous photocatalysis (Sczechowski, J. G. et al. (1995). *A Taylor vortex reactor for heterogeneous photocatalysis*, Chem. Eng. Sci. 50:3163).

Recently, the inventor herein (Forney, L. J., and Pierson J. A., (2003), *Optimum photolysis in Taylor-Couette flow*, AIChE 1.49:727-733; Forney, L. J. and Pierson, J. A. (2003), *Photolytic reactors: similitude in Taylor-Couette and channel flows*, AIChE J. 49:1285-1292, both of which are incorporated by reference in their entirety as if fully set forth herein) considered a fast photolytic reaction and demonstrated that optimum photoefficiencies could be achieved if the radiation penetration depth were controlled in relation to the velocity, boundary layer thickness. The latter work also provided a scaling law for the yield in both Taylor-Couette and channel flows. An earlier version of the scaling law is given in Eq. (7) and with improved microbe data a revised version is given in Eq. (55).

Thus, there is a need for systems and methods for the non-thermal processing of fluids.

There is another need for systems and methods for the non-thermal control of micro-organisms in edible fluids.

SUMMARY

Methods and systems for meeting the aforementioned needs are provided. More particularly, methods and systems for establishing Taylor-Couette flow in a fluid are provided to address said needs. Aspects of the methods and systems are useful for the irradiation of microorganisms in the fluid. Exemplary methods and systems incorporate Taylor-Couette flow in combination with a source of radiation. Such a combination can provide more uniform radiation exposure to the fluid and components of the fluid.

One aspect provides a method and system for disinfecting a fluid that includes introducing a fluid containing an organism, for example a micro-organism, into a reactor. The reactor typically includes a rotor having an outer wall. The rotor is housed within an outer cylinder. The outer cylinder includes an inner annular wall. The outer wall of the rotor and the inner wall of the outer cylinder define a first annular channel or gap. The outer cylinder also includes an inlet and an outlet in fluid communication with the annular channel or gap. An electromagnetic energy source is associated with the outer cylinder for irradiating the fluid in the annular channel or gap with an anti-microbial amount of electromagnetic energy. When the reactor is filled with fluid to be sterilized or disinfected, the rotor speed is controlled to create laminar Taylor Couette flow (laminar vortices) in the fluid in the annular channel or gap. The rotor speed can be regulated with a controller that can vary the rotation of the rotor to form laminar vortices in the fluid, for example inducing Taylor numbers in the fluid of about 100 to about 600. Controllers are known in the art and conventional controllers can be used so long as they can control the rotor to induce laminar vortices or Taylor numbers.

A Taylor number in the range of $100 \leq Ta \leq 600$ provides laminar Taylor vortices that transport microbes toward the radiation field near the walls of the fluid gap. The flux of radiation to the microbes is also strongly influenced by the ratio of the radiation penetration depth-to-fluid gap width, or as defined below λ/d .

A further embodiment includes a second annular channel or gap interior of the outer wall of the rotor providing a second

annular channel or gap for receiving the fluid. The first and second annular channels being in communication with each other.

An exemplary method for irradiating a fluid includes inducing laminar Taylor vortices in a fluid containing an organism, for example by generating a Taylor number in the fluid of between about 100 to about 600 (representing laminar Taylor vortices); and irradiating the fluid with an anti-microbial amount of energy. The anti-microbial amount of energy can be ultraviolet light in an amount sufficient to kill or inhibit microbial growth in the fluid or render the fluid safe for human consumption. Suitable fluids include, but are not limited to, foodstuffs such as beverages, milk, juice, soft drinks, or alcoholic beverages, and waste water. In another embodiment, the ratio of the penetration depth of the energy to the gap width in the fluid is about 0.25, more preferably from about 0.2 to about 0.3.

Other systems, methods, features, and advantages of the present invention will be or become apparent to one with skill in the art upon examination of the following drawings and detailed description. It is intended that all such additional systems, methods, features, and advantages be included within this description, be within the scope of the present invention, and be protected by the accompanying claims.

BRIEF DESCRIPTION OF THE FIGURES

Many aspects of the present disclosure can be better understood with reference to the following drawings. The components in the drawings are not necessarily to scale, emphasis instead being placed upon clearly illustrating the principles of the present invention. Moreover, in the drawings, like reference numerals designate corresponding parts throughout the several views.

FIG. 1A is an illustration of Taylor vortices between two concentric cylinders. Inner cylinder rotating, outer cylinder at rest; d—width of annular gap; L—cylinder; R=cylinder radius.

FIG. 1B is an expanded view of Taylor vortices of FIG. 1A.

FIG. 2 is cross-sectional view of an exemplary embodiment of a system of the present disclosure for disinfecting or sterilizing a fluid including Taylor-Couette reactor.

FIGS. 3A and B are cross sections of an exemplary Taylor-Couette reactor of the present disclosure showing symmetric (FIG. 3A) and grouped irradiating lamp configurations (FIG. 3B).

FIG. 4 is a cross section of another embodiment of the present disclosure.

FIG. 5 is a diagram of a square reaction channel.

FIG. 6 is a line graph showing *E. coli* inactivation versus Taylor number.

FIG. 7 is a line graph showing *E. coli* inactivation versus flow rate for various Taylor numbers. $Ta=0$ corresponds to flow between concentric cylinders.

FIG. 8 is a line graph showing *E. coli* inactivation versus flow rate for symmetric and grouped lamp configurations. $Ta=0$ corresponds to flow between concentric cylinders.

FIG. 9 is a line graph showing *E. coli* inactivation versus flow rate for symmetric and grouped lamp configurations. $Ta=100$ corresponds to Taylor-Couette flow.

FIG. 10 is a line graph showing fractional *E. coli* inactivation versus UV dosage.

FIG. 11 is a line graph showing fractional *E. coli* inactivation versus dimensionless UV dosage for Taylor-Couette flow; n is the correction factor for the effects of the concentration boundary layer; m is the ratio of the average fluid UV

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intensity-to-the intensity at the quartz lamp surface; I_0 is the average UV intensity at the lamp surface; K is the inactivation rate constant for *E. coli*.

FIG. 12 is a line graph showing fractional *E. coli* inactivation versus dimensionless UV dosage for Taylor-Couette flow (Ta=100). The flow between concentric cylinders (Ta=0) and channel flow. Parameters are the same as in FIG. 11.

FIG. 13 is a line graph showing the percent change in outlet triiodide concentration versus the ratio of radiation penetration depth to velocity boundary layer thickness.

FIG. 14 is a comparison of *E. coli* inactivation between experimental results and numerical simulations with laminar Poiseuille flow. (Reactor length $L=77.9$ cm and gap width $d=0.515$ cm).

FIG. 15 is a comparison of *Y. pseudotuberculosis* inactivation between experimental results and numerical simulations in turbulent flow. (Gap width $d=0.515$ cm).

FIG. 16 is a comparison of *E. coli* inactivation between experimental results and 2D numerical simulations with different Taylor numbers when $Q=40$ mL/min, $A=11$ cm⁻¹ and $d=0.572$ cm.

FIG. 17 is a comparison of *E. coli* inactivation between experimental results and numerical simulations versus average residence time when Ta=300, $A=11$ cm⁻¹ and $d=0.572$ cm.

FIG. 18 is a comparison of *E. coli* inactivation between experimental results and 2D numerical simulations with different penetration depths when $Q=40$ mL/min., Ta=300 and $d=0.572$ cm.

FIG. 19 presents a correlation of experimental data for UV disinfection in turbulent and laminar Taylor-Couette reactors.

FIG. 20 presents a correlation of numerical results for UV disinfection in turbulent and laminar Taylor-Couette reactors.

FIG. 21 presents a profile of radiation intensity across the gap for laminar, turbulent or Taylor-Couette flow. Order of λ/d values in caption is the same order in graph.

FIG. 22 shows changes in microbe inactivation levels with a change in λ/d in laminar Poiseuille flow.

FIG. 23 shows changes in microbe inactivation levels with a change in λ/d in turbulent flow.

FIG. 24 shows changes in microbe inactivation levels with a change in λ/d in laminar Taylor-Couette flow.

FIG. 25 is a comparison of inactivation for three flow patterns. (Dosage is $I_0\tau=2870$ mJ/cm² and absorption coefficient $A=40$ cm⁻¹).

FIG. 26 illustrates fluid streamlines in Taylor-Couette flow.

FIG. 27 shows fluence distribution for three flow patterns. (Ta=200 for Taylor-Couette flow, $A=10$ cm⁻¹, $d=4$ mm).

FIG. 28 shows microbe inactivation for laminar and turbulent Taylor-Couette flow. (Axial $Re=Re_h$, the hydraulic Reynolds number).

DETAILED DESCRIPTION

Embodiments of the present disclosure provide methods and systems for producing Taylor-Couette flow in a fluid. The fluid can be exposed to an energy source, for example an electromagnetic energy source such as an ultraviolet light emitting lamp or other non-thermal energy source. Suitable UV lamps emit radiation in the range of about 200-400 nm, preferably about 200-280 nm. The exposure of the fluid to the energy source can also catalyze a chemical reaction in the fluid or in components of the fluid. One embodiment provides a system and method of irradiating a fluid in the absence of a catalyst. Additionally, irradiating the fluid with energy can kill or inhibit the growth of organisms such as microorgan-

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isms, in the fluid. The term "organism" includes single and multicellular animals, viruses, protozoa, bacteria, fungi, pathogens, and the like.

In one embodiment, the flow characteristics of the fluid approach that of plug flow but with a residence time that is uncoupled from the hydrodynamics or boundary layer characteristics. For example, one exemplary system of the present invention includes an inner cylinder that rotates within a stationary but larger outer cylinder as shown in FIG. 2 (Schlichting, H. (1979) Boundary Layer Theory, 7th Ed. McGraw-Hill Book Co, NY). At low rotation rates a laminar, hydrodynamic configuration called Taylor-Couette flow is established consisting of a system of circumferential vortices within the annular fluid gap. The latter constitutes a spatially periodic flow that is the hydrodynamic equivalent to cross flow over a tube bank or lamp array. These vortices provide radial mixing, reduce the boundary layer thickness and are independent of the axial flow rate and thus the fluid residence time. An additional feature of the rotating design is the repetitive exposure of the fluid parcels to a minimum number of energy sources, for example lamps, which substantially reduces the maintenance requirements. This repetitive exposure also provides a cumulative exposure to radiation more efficiently and effectively than the application of a single dose. Laminar vortices can be formed in the fluid by introducing the fluid into the disclosed reactors, for example a reactor having a rotor within a hollow cylinder.

An exemplary reactor is shown in FIG. 2. The reactor includes rotor 205 positioned within an inner hollow of an outer cylinder 240. An annular fluid gap 215 is formed between the inner cylinder of rotor 205. When the rotor rotates within the inner hollow of outer cylinder 240, Taylor-Couette flow is produced in the fluid within annular fluid gap 215. The rotor speed can be regulated with a controller 245 that can vary the rotation of the rotor to form laminar vortices in the fluid. Controllers are known in the art and conventional controllers can be used so long as they can control the rotor to induce laminar vortices or Taylor numbers of about 40 to about 600. The circumferential vortices 110 produced in the fluid cause parcels in the fluid to rotate as shown in FIGS. 1A and 1B. The rotation of the parcels permits the parcels to be repeatedly exposed, for example, to an energy source 220. To maximize the exposure of energy, such as ultraviolet light, to the parcels, a reflector 225, such as an aluminum reflector, can be placed around the exterior surface of energy source 220 to redirect scattered energy into the fluid. The reflector can be made of any reflective material including metals such as aluminum, tin, silver, glass, or a conventional mirror. The outer cylinder typically has walls 210 composed of material that enables energy such as ultraviolet light to pass there-through without an appreciable loss of energy due to absorption, refraction, or reflection. Suitable wall material includes quartz, glass, and synthetic polymers, and may include any transparent medium.

Fluid enters the reactor via inlet 235, which is optionally positioned at the base of outer cylinder 240. When rotor 205 is actuated to begin rotating, Taylor-Couette flow is established. Fluid exits the reactor through outlet 230, optionally positioned at or near the top of outer cylinder 240. The fluid can be any fluid including water, solutions, bodily fluids such as blood and the like, wastewater, effluent, wash water, and other waste water, or fluid foodstuffs including, but not limited to milk, juice, soft drinks, nutrient drinks, diet supplements, and alcoholic drinks, etc. The fluid can be irradiated by the energy source to facilitate chemical reactions in or with the fluid. Alternatively, irradiation of the fluid with energy from energy source 220 can serve to disinfect or sterilize the

fluid. In one embodiment, the irradiation energy is not in the form of heat. Embodiments of the present invention advantageously preserve the activity of endogenous nutrients and enzymes in the fluid by using anti-microbial amounts of non-thermal energy.

In another embodiment, at least one energy source 220 is positioned tangentially to the outer cylinder wall 210. Suitable energy sources include electromagnetic energy sources including microwave energy sources, ultraviolet light sources, sound wave sources, visible light sources, infra-red light sources, X-ray sources, gamma ray sources, electron sources, atomic and sub-atomic particle sources, and the like. FIG. 3A illustrates another exemplary embodiment of the reactor having a plurality of energy sources 220 positioned equidistant (symmetrically) around the outer cylinder 210. It will be appreciated that the energy sources can be placed in any position around the annular fluid gap 215 such that the energy emitted from the energy source 220 is directed into the fluid in the annular fluid gap 215. FIG. 3B shows a plurality of energy sources 220 grouped together and positioned opposite inlet 235.

FIG. 4 is a cross-sectional side view of still another embodiment of the present disclosure. In this embodiment, fluid enters the reactor through inlet 450 which is in fluid communication with a channel 405A. Channel 405A is in fluid communication with inner hollow 445. The reactor includes rotor 405 having a channel 440 between an outer wall 410 and an inner cylinder 415. Rotor 405 is housed or positioned within outer cylinder 455 such that the outer wall 410 of rotor 405 separates annular channel 405 A. This embodiment provides multiple annular channels 110, 470 and 475 in which laminar Taylor-Couette vortices can be formed.

Outer cylinder 455 includes an inner annular wall 420 defining a circular hollow 445 for receiving inner cylinder 415 of rotor 405. Outer annular wall 460 defines annular channel 110, channel 405a and annular channel 475 between outer annular wall 460 and inner annular wall 420. Annular channel 405 receives outer wall 410 of rotor 405. Annular wall 420 also separates annular channel 470 and annular channel 475 when rotor 405 is positioned within outer cylinder 455. Fluid traverses through the annular channels and exits through outlet 430. Outlet 430 is optionally positioned at the base of outer cylinder 455, for example in the center of the base of outer cylinder 455 and opposite inner cylinder 415. As the fluid traverses the annular channels, it is moved through multiple circumferential vortices exposing the fluid and particles in the fluid to energy source 425. The design illustrated in FIG. 4 has three continuous annular fluid channels 110, 470 and 475 of equal length. This design allows for the same number of vortices as a design having a single annular channel three times the height as one of the channels of FIG. 4. The design of FIG. 4 allows for a shorter rotor and reactor. Alternatively, two or more annular channels can be provided.

Energy source 425 can be integral with annular walls 460, 410, 420, or a combination thereof. Alternatively, energy source 425 can be removably affixed to annular walls 460, 410, 420, or a combination thereof or can form all or part of the walls. Energy from energy source 425, such as ultraviolet light, can irradiate fluid as the fluid traverses annular channels 405 and 440. Taylor vortices formed in the annular channels when the rotor is actuated cause the fluid and components in the fluid to rotate as shown in FIGS. 1A and 1B and increase the exposure of the fluid and components of the fluid to energy source 425.

The effects of flow rate, energy source location and cylinder rotation rate were considered for the inactivation of bacteria, for example *Escherichia coli*. These results are com-

pared with similar data in a conventional channel. Details of the correlation of the data are also provided based on assumed inactivation kinetics and a plug flow reactor material balance. The latter analysis also introduces a new correction factor that accounts for the important boundary layer effects.

Another embodiment provides a Taylor-Couette reactor that provides excellent liquid surface renewal for the application of electromagnetic waves to chemical processing. The photoefficiency of such processes is affected by the penetration depth of radiation into the fluid relative to the velocity boundary layer thickness. The secondary flow caused by the presence of laminar vortices decreases the boundary layer thickness so that the dosage of radiation is substantially increased for fluids with large radiation absorptivities. In another embodiment, the maximum photoefficiencies occur when the radiation penetration depth is equal to the boundary layer thickness.

Materials and Methods

Bacterial Culture

The *Escherichia coli* was obtained from the American Type Culture Collection, culture number 15597 (Manassas, Va.). The *E. coli* culture was grown and maintained on tryptic soy agar (TSA; Difco Laboratories) and tryptic soy broth (TSB; Difco Laboratories). *E. coli* was aseptically rehydrated using plates containing ATTC medium 271 agar at 37° C. for 24 hours. Colonies were transferred to agar slants and refrigerated at 4° C. For each experiment, colonies were aseptically transferred to a test-tube containing 10 mL Acumedia 7164A Tryptic Soy Broth. Test-tubes were placed in a Fisher Versa-Bath-S Model 224 temperature waterbath for 24 hr (37° C. and 30 rpm agitation rate). One mL of broth solution was diluted to 1-liter deionized water to obtain the 10⁶ CFU/mL influent.

Wastewater

To mimic the bacterial load in wastewater, simulated wastewater was spiked with 10⁶ CFU/mL of the indicator organism *Escherichia coli*. The wastewater was sampled and *E. coli* colonies were enumerated on tryptic soy agar in order to determine *E. coli* survival. To simulate wastewater, bentonite which is a colloidal silica of specific gravity of about 2.0 was added to establish a total suspended solids (TSS) concentration and turbidity, with full transmittance (FT) values no less than 55%, turbidity less than 2 to 3 NTU, and TSS less than 5 mg/L.

Taylor-Couette Flow

A Taylor vortex column was constructed of 4.6 cm internal diameter, fused quartz stator (Vycor) with a teflon rotor of 3.8 cm diameter by 13 cm in length as shown in FIG. 2. The resulting annular gap width *d* was 0.4 cm. The inlet consisted of one 6 mm tube located 13 mm from the bottom of the reactor. The irradiated holdup volume within the annular gap was 16.2 ml. Flow rates were varied from 13.1 to 136.8 ml/min. with a positive displacement pump. Four cold cathode, low pressure mercury UVC lamps with effective lengths of 3.1 cm [Gilway Technical Lamp. 2001. catalog #169.] were positioned equidistant around the outer quartz stator. In a second configuration the lamps were grouped 180 degrees from the inlet such that adjacent lamps were separated by a distance of approximately 2 mm as shown in FIG. 3B.

Lamps were surrounded with an aluminum reflector 225 as shown in FIG. 2. Lamp output (mW) was determined with an International Light IL1471A germicidal radiometer system (IL1400A monitor and SEL240/QNDS2/TD sensor) providing a spectral range of 185-310 nm and a measurement range of 33 μW/cm² to 330 mW/cm². Lamp intensity (mW/cm²)

was measured after lamps were energized for 20-minutes. When all four lamps were placed on the sensor with an aluminum reflector background, the intensity for the sensor area was recorded as 4.85 mW/cm². The intensity for all four lamps was further recorded as 4.0 mW/cm² at 1 cm from the sensor surface. The intensity of radiation for each lamp (wavelength ~254 nm) was therefore rated at about 1 mW/cm at one cm from the lamp center.

The angular rotation of the rotor was controlled by a permanent magnet DC motor providing Taylor numbers over a range from 0<Ta<1000 where $Ta = [Ud(d/R)^{1/2}]/\nu$. Here, $U = \omega R$ is the rotor surface velocity, the angular frequency to $\omega = 2\pi f$, f is the rotor frequency, R is the rotor radius, d is the gap width and ν is the kinematic viscosity of the fluid.

Channel
A continuous flow reactor channel 500, 18.5 cm in length, including two PVC flow straighteners at both ends was constructed from a bronze 2x2 cm ID square. Centered in the channel 520 was a fused quartz capillary tube 510 as shown in the cross section of FIG. 5. The quartz tube 510 holds one cold cathode, low pressure, mercury UVC lamp 515 with a total effective irradiated length of approximately 7.8 cm. The intensity of radiation for the lamp (wavelength of about 254 nm) was about 1 mW/cm² at 1 cm from the center.

The irradiated volume of the reactor was 28.6 ml and the flow rates covered a range of values from 10<q<40 ml/min. The reactor Reynolds number covered the range 6<Re<25 for the indicated flow rates providing fully developed laminar flow in the cross sectional area. The cross sectional area of the channel is $A_c = 3.9$ cm² with a hydraulic diameter of $d_h = 1.52$ cm. An estimate of the laminar film thickness is $\delta = d_h/4 = 0.38$ cm that corresponds to the distance to the centerline of the asymmetric cross section.

Plug Flow Reactor

The following analysis is an adaptation of that presented by Severin et al. (Severin, B. F. et al. (1984) *Kinetic modeling of UV disinfection of water. Inactivation kinetics in a flow-through UV reactor*, J WPCF. 56:164-169) who considered a completely mixed flow-through reactor. Here, we consider a plug flow geometry also of annular design with a radiation source I_o at radius r_o along the axis. The kinetics of inactivation are assumed to be first order with respect to both the surviving organism density and the light intensity. Thus, the local disinfection rate R becomes

$$R = KI(r)N(r, x) \quad (1)$$

where

R =disinfection rate (organisms/cm³-sec)

K =rate constant (mW-sec/cni²)⁻¹

$I(r)$ =radiation intensity at radius r , and

$N(r, x)$ —surviving organism density at radius r and axial position x (organisms/cm³).

From Lambert's law for a radiation source of infinite length, one obtains

$$I(r) = (r_o I_o) \exp(-E(r - r_o)) \quad (2)$$

where I_o is the radiation intensity at the quartz tube surface of radius r_o , $E = 2.3A$ and A is the solution absorbance.

A local material balance for the surviving organism concentration in an ideal plug flow reactor can be approximated in the form

$$q(dN) = -KN(x)I(r)dV \quad (3)$$

where we have assumed that N is a constant with radius. Here, q is the volume flow rate and $V = \pi(r_f^2 - r_o^2)L$ is the volume of

the reactor and $dV = 2\pi r dr dx$. Substitution of Eq. (2) into Eq. (3) and integrating over $r_o < r < r_f$ one obtains

$$dN/N = -mKI_o \tau dx/L \quad (4)$$

5 where $N = N_o$ at $x = 0$ and $\tau = V/q$ is the retention time. Thus, the outlet concentration of surviving organisms becomes

$$N_f/N_o = \exp(-mKI_o \tau) \quad (5)$$

The dimensionless factor m in Eq. (5) is the ratio of the average light intensity in the reactor to the intensity at the surface of the quartz tube as derived by Severin et al. (Severin, B. F. et al. (1984) *Kinetic modeling of UV disinfection of water. Inactivation kinetics in a flow-through UV reactor*, J WPCF. 56:164-169) where

$$m = 2r_o \alpha [1 - \exp(-E(r_f - r_o))]/[E(r_f^2 - r_o^2)]. \quad (6)$$

It should be noted that for transparent fluids or $E < 1.0$, $m \approx 2r_o/(r_o + r_o)$.

If the concentration of surviving organisms N is not constant with radius and a concentration boundary layer exists, then the argument of the exponent of Eq. (5) would be reduced by a factor $n < 1.0$. This is the result of a reduced N in the local disinfection rate of Eq. (1) near the irradiated wall where the radiation intensity is the largest. Thus, one obtains

$$N_f/N_o = \exp(-nmKI_o \tau) \quad (7)$$

where n is an empirical constant that is independent of axial distance for fully developed flow. Similar arguments were made in the study of photolytic reactions for such laminar plug flow geometries by Forney and Pierson (Forney, L. J. and Pierson, J. A. (2003b), *Photolytic reactors: similitude in Taylor-Couette and channel flows*, AIChE J. 49:1285-1292) which is incorporated herein in its entirety.

EXAMPLE 1

Taylor Number

Values for the inactivation of *E. coli* in the Taylor column were recorded at increasing rotation rates up to roughly 300 rpm corresponding to a Taylor number of 1000. The data shown in FIG. 6 indicate a minimum of a 4-log reduction in surviving *E. coli* in units of colony forming units per ml or cfu/ml at a value of $Ta = 100$ or roughly 30 rpm (~0.5 Hz). Although the value of $Ta = 100$ is somewhat above the critical value of $Ta = 41$ for the onset of laminar Taylor vortices, $Ta = 100$ represented an incremental reduction of roughly 1 or 2-logs in cfu/ml compared to other values of Ta with comparable flow rates as shown in both FIGS. 6 and 7. At roughly 50 $Ta = 600$ the vortices become turbulent and the residence time distribution of the fluid broadens such that the characteristics of the Taylor column approach that of a completely mixed flow-through reactor. For values of $41 < Ta < 600$ in the laminar range the reactor characteristics approach that of ideal plug flow with decreasing Ta .

As indicated in FIG. 6 the optimum rotation rate is in the laminar range of Ta . At higher rotation rates the bentonite is probably forced to the outer stator surface which in turn absorbs the applied UV radiation. All data recorded in the experiment constitute the average of at least two measurements of surviving *E. coli* for fixed operating conditions. The error bar for the data point at the minimum in FIG. 6 indicates the values for two independent measurements of *E. coli*. The remaining data with the same error or uncertainty of roughly 60 10^2 cfu/ml per point was insignificant compared to the larger concentrations of *E. coli* on the log plot. Also recorded in FIG. 6 are the influent concentrations of *E. coli* along with the

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expected error. The latter error was determined by measuring the *E. coli* concentrations both before and at the conclusion of the experiments.

EXAMPLE 2

Flow Rate

Values of *E. coli* inactivation were recorded at increasing flow rates for three values of the Taylor number $Ta=0$, 100 and 120. As indicated in FIG. 7 the inactivation levels decreased with higher flow rates for all values of Ta since the radiation dose $\propto 1/q$ where q is the volumetric flow rate through the reactor. A value of $Ta=100$ provides the largest inactivation rates for all recorded flow rates. Significantly, the plot also indicates an increase of over 2-logs for *E. coli* inactivation compared to simple flow through concentric cylinders ($Ta=0$) for moderate flow rates of 20 to 40 ml/min.

EXAMPLE 3

Lamp Symmetry

The effects of lamp location on inactivation were measured and the data are recorded in FIGS. 8 and 9. FIG. 8 with no rotation or $Ta=0$ demonstrates that channeling of the pathogens occurs between concentric cylinders when the lamps are grouped on the side of the reactor opposite the fluid inlet.

For the symmetrical case of equidistant lamp location and at $Ta=100$, FIG. 9 illustrates that an improvement of over a 1-log reduction in surviving organisms was again observed compared to the grouped geometry for moderate flow rates between $20 < q < 60$ ml/min. Moreover, the improvement was somewhat less than 1-log at higher flowrates $q > 60$ ml/min at lower photon dosages. One concludes that there is a significant loss of photons from both reflection and transmission through multiple lamps in close proximity,

EXAMPLE 4

Dosage

The inactivation of *E. coli* was measured for the channel and the data are compared in FIG. 10 to the results taken with the Taylor column at $Ta=0$ and 100. In FIG. 10 the UV dosage was computed based on the average radiation intensity within the fluid times the fluid residence time. The value of m defined by Eq. (6) that represents the ratio of average intensity within the fluid-to-the quartz surface value was estimated from the approximation $m=2r_o/(r_o+r_f)=0.42$ for low fluid absorbance where r_f is equal to the radius of a circle with the same cross sectional area as the square channel in FIG. 5. The corresponding values of m for the annular gap in the Taylor column were estimated to be $m=1.0$ since the lamps were located outside the gap with photo reflection inward toward the rotor.

The lamp intensity I_o in units of mW/cm² at the quartz tube surface for the channel in FIG. 5 was computed from the lamp length and tube diameter. To compute I_o , the total mW output from the 7.8 cm effective lamp length was divided by the quartz tube surface area. Similarly, to compute the average light intensity I_o of the inside surface of the quartz stator in the Taylor column, the total lamp output in mW for 4 lamps with an effective length of 3.1 cm per lamp was divided by the total surface area computed from the inside diameter of the quartz stator (length of 3.1 cm). The intensity of radiation for both the channel and the Taylor column were based on an assumed

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absorption of 6% for the quartz tube (GE 124) and 27% for the quartz stator (Vycor Corning 7913), respectively.

The results in FIG. 10 indicate more than a 3-log reduction in the inactivation of *E. coli* with Taylor-Couette flow compared to a conventional channel at moderate flow rates of $20 < q < 40$ ml/min. These conclusions are based on an equal radiation dosage in units of mJ/cm² within the fluid.

EXAMPLE 5

One of the major problems that one must contend with during the continuous use of UV reactors is the maintenance requirement of both cleaning the numerous lamp surfaces from fouling and replacement of defective lamps. The use of Taylor-Couette flow provides repetitive contact of fluid parcels with a minimum number of lamps. For example, in one embodiment described herein operating at $Ta=100$, with four lamps and a flow rate of 20 ml/min, a given fluid parcel will make roughly 25 revolutions before reaching the outlet. Therefore, with four lamps per revolution, a parcel of fluid therefore makes contact with the equivalent of 100 lamps as it passes through the Taylor column.

The optimum inactivation data for $T \delta=100$ with the Taylor column can be replotted in the form suggested by Eq. (7). The inactivation rate constant for *E. coli* or $K=0.89$ cm²/mW-s that appears in the independent variable $\ln K I_o \tau$ was substituted from the batch inactivation data from (Severin, B. F. et al. (1984) *Kinetic modeling of UV disinfection of water. Inactivation kinetics in a flow-through UV reactor*, J WPCF. 56:164-169). The remaining value of the boundary layer, correction factor n can be estimated by comparison with the data. The resulting plot is shown in FIG. 11 which is data replotted from FIG. 10 with a value of $n=0.28$ in Eq. 1 that places the theory through the first six data points. As illustrated in FIG. 11, all of the fractional inactivation data appear to conform to the model of a plug flow reactor with the exception of those data taken at the low flowrates near $q=20$ ml/min on the left of FIG. 10. These latter data are subject to both the effects of the centrifugal forces leading to an increase in the bentonite concentrations near the transparent stator surface and to gravitational settling of the silica colloid at the inlet passage.

In a similar fashion, all of the data of FIG. 10 were replotted in FIG. 12 with estimates of the boundary layer, correction factor n for each case as shown in the figure caption. Again, all of the data appear to conform to the plug flow model. It is interesting to note that estimated values of n in FIG. 11 appear to decrease with increasing boundary layer thickness. The latter observation conforms to the earlier work of Forney, L. J. and Pierson, J. A. (2003), *Photolytic reactors: similitude in Taylor-Couette and channel flows*, AIChE J. 49:1285-1292 which suggests that the yield from photolytic reactions in fully developed laminar reactors $n \propto 1/\delta$ where δ is the velocity boundary layer thickness or that $n \propto 1/\delta$ in Eq. (7).

Table 1 shows a comparison with the empirical values of n used in FIG. 12 with the expression $n=0.023/\delta$. The empirical values of n were chosen in FIG. 12 and Table 1 such that there were an equal number of data points both above and below the theory. Moreover, in Table 1 the values of the velocity boundary layer thickness were taken from Forney, L. J. and Pierson, J. A. (2003), *Photolytic reactors: similitude in Taylor-Couette and channel flows*, AIChE J. 49:1285-1292 where δ was estimated to be $dh/4$ for both the channel and the case of flow between a concentric cylinders ($Ta=0$) where dh is the hydraulic diameter. The value of 5 for the case $Ta=100$ was

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estimated to be on the order of $Ta^{-1/2}$ (Forney, L. J., and Pierson, J. A. (2003) *Optimum photolysis in Taylor-Couette flow*, AIChE J. 49:727-733).

The common problems of non-uniform radiation levels and concentration boundary layer effects are largely eliminated in UV reactors with the use of Taylor-Couette flow that is the hydrodynamic equivalent to cross flow over a tube bank (Baier, G. et al. (1999). *Prediction of mass transfer in spatially periodic systems*, Chem. Eng. Sci. 54:343) or for this application a lamp array. Moreover, the repetitive exposure of fluid parcels to a small number of lamps decreases maintenance requirements. Over a 3-log reduction in the inactivation of *E. coli* under the best conditions was demonstrated compared to a conventional channel with the same radiation dosage. Moreover, greater than a 2-log reduction was evident compared to flow through concentric cylinders.

The inactivation data for three reactor geometries of Taylor-Couette flow and flow between either concentric cylinders or a square channel are correlated with the assumption of plug flow. In particular, the effects of non-uniform radiation levels are accounted for by integration across the fluid channel as done in the past but a new correction factor is introduced that is inversely proportional to the velocity boundary layer thickness to account for the effects of a concentration boundary layer.

TABLE 1

Prediction of Boundary Layer Correction Factor-n			
Flow Geometry	Boundary Layer Thickness - δ (cm)	n	
		0.023/ δ	empirical (FIG. 11)
Taylor-Couette $Ta = 100$	0.08	0.28	0.28
Concentric Cylinders $Ta = 0$	0.2	0.11	0.09
Channel	0.38	0.06	0.06

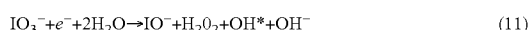
EXAMPLE 6

Photochemistry

Fast UV photolysis of aqueous iodide producing triiodide was also investigated. Concentrated KI solutions are optically opaque at wavelengths of 254 nm and act as photon counters. UV absorption by iodide leads to an aqueous or solvated electron via a charge transfer-to-solvent reaction and the formation of an excited iodine atom. The essential reactions are listed below,



As noted, the UV-induced formation of triiodide is potentially limited by the back reaction of Eq. (9). The quantum yield for triiodide is significantly increased, however, by the addition of potassium iodate. In the presence of iodate, scavenging of the bulk electron occurs and the following additional reaction is proposed



The yield of the triiodide photoproduct is easily monitored by spectrophotometry at either 350 or 450 nm depending on the

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concentration. The quantum yield of $\phi = 0.75$ mol./einstein is relatively constant with either temperature or reagent iodide concentrations. With the addition of a borate buffer (pH 9.25) to minimize thermal oxidation, stock solutions of 0.6 M KI and 0.1M KIO_3 with the borate buffer are stable and insensitive to ambient light in the visible spectrum. Radial mass transfer in Taylor-Couette flow has been documented in terms of a Sherwood number Sh of the form

$$Sh \propto Ta^{1/2} Sc^{1/3} \quad (12)$$

where the Taylor number

$$Ta = (\omega R d / \nu) (d R)^{1/2} \quad (13)$$

The indicated exponents in Eq. (12) were determined previously by a number of experiments and also confirmed by the recent numerical predictions. The torque coefficient CM for Taylor-Couette flow is of the form

$$C_M = 2M / (\pi \rho \omega^2 R^4 h) \propto Ta^{-1/2} \quad (14)$$

for the range of Taylor numbers $Ta_c < Ta < 400$ where the critical Taylor number $Ta_c = 41$ indicates the onset of laminar vortices. Here, the moment $M = \tau (2\pi R^2)$ and τ is the shear stress on the rotor.

Equations (12) and (14) suggest that the transport coefficients in laminar, Taylor-Couette flows are correlated by a Chilton-Colburn analogy of the form

$$J_D = Sh / (Ta Sc^{1/3}) = C_M / 2 \quad (15)$$

For the values $40 < Ta < 400$ and the Schmidt number $Sc = \nu / D > 1$, These conclusions are consistent with laminar and heat transfer correlations on a spinning disc but with Ta replaced by the Reynolds number based on the disc angular velocity and diameter.

Consider now a laminar boundary layer with a linear velocity and concentration profile (film model) on the surface of a Taylor-Couette flow ($Ta > Ta_c$). Since the mass transfer coefficient $k_c \propto D / \delta_c$ and the Sherwood number

$$Sh \propto k_c d / D \quad (16)$$

where δ_c is the concentration boundary layer thickness, d is the gap width and D is the solute molecular diffusivity, one obtains

$$Sh d / \delta_c \propto (d / \delta) (\delta / \delta_c). \quad (17)$$

Since a boundary layer analysis confirmed by experiment suggests $\delta_c / \delta \propto Sh^{1/3}$, one obtains a ratio of characteristic reactor length d -to-velocity boundary thickness

$$d / \delta \propto Ta^{1/2} \quad (18)$$

for $Ta > Ta_c$.

Attempts to obtain Eq. (18) by stretching the characteristic lengths d or δ for a boundary layer on a flat plate by a factor of $(d/R)^{1/2}$ were unsuccessful. There is some evidence, however, that the Sherwood number $Sh \propto Ta^{1/2} Sc^{0.17} (d/R)^{0.17}$ from the mass transfer experiments of Holeschovsky and Cooney but, again, the exponent magnitude of 0.17 is inconsistent with the attempted boundary analysis that would suggest larger values.

Fast photochemical reactions must occur near transparent reactor walls. The thickness of the reaction layer, however, is not confined to a fraction of the velocity boundary thickness, but rather to the radiation penetration depth. The latter depth, in fact, can exceed both the boundary thickness or characteristic reaction dimension depending on the absorbance of the reacting solution.

Since the solution absorbance is defined by

$$A = \epsilon c L \quad (19)$$

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where the intensity of radiation is $I/I_0=10^{-A}$, ϵ is the extinction coefficient, C is the absorbing species and A , is the radiation depth, the reaction layer is therefore confined to a layer on the order of

$$A\alpha I/\epsilon C. \quad (20)$$

An additional dimensional parameter is the maximum possible concentration of photochemical product formed. The latter is equal to the product of the number of photons introduced into the reactor and the quantum efficiency of the reaction. The maximum concentration of product formed is thus

$$C_m = nI_0 A_1 \phi \gamma q \quad (21)$$

where n is the number of lamps, I_0 , is the intensity of radiation [W/cm²], A_1 is the area of a single lamp, ϕ is the reaction quantum efficiency [mol product/einstein], q is the reactor volume flow rate and γ [J/einstein] is the conversion factor from a mol of photons to joules of energy.

Dimensional arguments suggest that the concentration of photochemical product formed C_ω is of the form

$$C_\omega/C_i(I) \propto f(C_m/C_i(I), \lambda/\delta) \quad (22)$$

provided the Taylor number $Ta > 0$ where $C_i(I)$ is the concentration of reactant iodide in the inlet stream. Simplifying Eq. (22) somewhat since a mass balance implies $C_\omega \propto C_m$, one obtains

$$C_\omega/C_i(I) \propto C_m/C_i(I) [f(\lambda/\delta)]. \quad (23)$$

Defining C_0 as the product concentration with no rotation, one now obtains an expression which isolates the effects of rotation in the form of the dimensionless quantity

$$(C_\omega - C_0)/C_0 = f(\lambda/\delta) \quad (24)$$

Another embodiment provides a Taylor vortex column having a bronze rotor 3.43 cm in diameter by 5 cm in length centered within a fused quartz beaker with an inside diameter of 4.1 cm providing a gap width of $d=0.334$ cm. The holdup volume (irradiated) was 12 ml with a range of flow rates between $15 \leq q \leq 50$ ml/min. Five cold cathode, low pressure mercury UVC lamps with effective lengths of 3.1 cm were positioned around the quartz beaker and surrounded by an aluminum reflector with an over 90% reflectivity of UV radiation. The intensity of radiation for each lamp (wavelength ~254 nm) was rated at 1.7 mW/cm² at the lamp surface providing a range of power input from 0.033 W to 0.164 W depending on the number of lamps engaged.

A solution of 0.6 M potassium iodide (KI) and 0.1 M potassium iodate (KIO₃) buffered (pH 9.25) with borate was pumped through the Taylor column. The absorbance of triiodide at the outlet was measured at either 350 or 450 nm for low or high concentrations, respectively, depending on the number of lamps engaged or liquid flow rate. The rpm of the rotor, controlled by a permanent magnet DC motor, was varied between 0 < rpm < 75 providing a Taylor number covering the range 0 < Ta < 200.

The triiodide absorbance as expected, clearly indicated a large increase of roughly 60% for Taylor numbers $Ta > Ta_c$, where the lower limit of $Ta_c=40$ corresponds to the onset of Taylor vortices at low axial Reynolds numbers. Since the cross sectional area for the flow within the gap is 4 cm², the axial Reynolds number was $Re < 10$ for all experiments and thus had no effect on the critical Ta_c .

Plug Flow Reactor

When the Taylor number $Ta > Ta_c$ and laminar vortices are present within the Taylor column, the flow can best be

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described as approximating that of an ideal plug flow reactor. Assuming a zero order rate expression at steady-state, one obtains

$$u dC/dx = -r \quad (25)$$

where the constant rate [mol/liter-s]

$$r = nI_0 A_1 \phi \gamma V \quad (26)$$

and V is the holdup volume of the reactor. Thus, the concentration of triiodide formed from Eq. (25) with $dx/u = dV/q$ is

$$C(I_3) = \beta r V / q \quad (27)$$

where the factor $\beta < 1$ accounts for both the loss of input radiant energy to liquid heating and surface absorption and the effects of back reactions from triiodide to iodide depleting the product as described later.

Normalized plots of Eq. (23) for the outlet triiodide concentration for increasing flow rates at fixed rpm ($Ta=100$) and the standard stock solution (0.6 M iodide) where C_m is defined by Eq. (14) show that the photo efficiency of the reactor is not high (<30%) so that axial variations in the iodide reactant and thus the radiation penetration depth are small consistent with the analysis.

Effects of Rotation

The effects of rotation are isolated by comparing the product concentration at fixed Taylor numbers $Ta > Ta_c$ with the product formed at zero rpm or $Ta=0$. Because of the large surface-to-volume ratio for the reactor, one would expect a considerable enhancement in the magnitude of the transport coefficients without vortices. A nearly constant 70% improvement in product yield occurs for all $Ta > Ta_c$.

Percentage increase in reaction product at fixed $Ta=100$ for various values of the radiation dosage were obtained by engaging one to five UV lamps and changing the flow rate between 16 and 32 ml/min. There is some scatter in the data possibly due to channeling through the reactor for the $Ta=0$ case, since the reactor inlet and outlet were located on the same side but 45° apart. Thus, the sequence of lamps in the circumferential direction was varied for several experiments with the same total power input leading to the indicated scatter. However, it is apparent from the data that the concentration of product formed due to rotation is independent of the dosage of radiation supplied as suggested by Eq. (24).

Optimum Rotation

The similarity law proposed by Eq. (24) was tested by varying the reactant concentration, that is, the concentration of iodide fed to the reactor inlet. Since the absorbance $A = \lambda \epsilon C_i(I)$ is 200 for a 0.6 M KI and 0.1 M KIO₃ solution, the extinction coefficient ϵ at a wavelength of 254 nm was calculated to be $\epsilon = 333 \text{ M}^{-1} \text{ cm}^{-1}$. Setting the absorbance $A=1$ that represents a radiation depth over which 90% of the UV photons are absorbed, one calculates the radiation depth to be $\lambda = 1/\epsilon C_i(I)$.

The stock solution of 0.6 M KI and 0.1 M KIO₃ along with a series of additional solutions with KI and KIO₃ in the same ratio but diluted by a factor of up to 100 were fed to the reactor. The product triiodide concentration was measured at both $Ta=0$ and 100 for each inlet solution. The data show that the reaction yield is inhibited if the reaction layer lies within the velocity boundary layer or $\lambda/\delta < 1$ (see FIG. 1B). Under these circumstances the large concentration of I_3^- within the boundary is reduced by the solvated electron e_{aq}^- back to I^- via the reaction



and the product yield of K is diffusion limited.

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FIG. 13 shows the percent change in outlet triiodide concentration versus the ratio of radiation penetration depth to velocity boundary layer thickness. If the reaction layer thickness is greater than the velocity boundary layer or $\lambda/\delta \gg 1$, the product I_3^- is formed throughout the gap and the advantages of the circulating vortices are substantially reduced. It should be noted that the left data point in FIG. 13 corresponds to a reaction layer that is 15% of the velocity boundary thickness where the latter is 10% of the gap width d . In contrast, the right data point in FIG. 13 represents a radiation depth that is 150% of the gap width d . At the optimum operating conditions $\lambda/\delta=1$ one obtains a maximum 150% increase in the product concentration. Under the latter constraint if

$$\lambda/\delta = Ta^{1/2}/(d\epsilon C_i(I)) \quad (29)$$

setting $\lambda/\delta=1$, one obtains an optimum frequency f_{op} Hz of rotation equal to

$$f_{op} = (\nu 2\pi)(dR)^{1/2} \epsilon^2 C_i^2(I) \quad (30)$$

Scale-Up

An efficient UV reactor requires multiple exposure of the pathogen to a fixed number of lamps positioned around the reactor circumference. The number of cycles of the pathogen around the axis of the reactor as the pathogen passes from inlet to outlet is N where

$$N = ft_r \quad (31)$$

and f is the rotor frequency (cycles/sec) and t_r is the fluid residence time or

$$t_r = V/q = \pi Ddh/q \quad (32)$$

Here, h is the rotor length, d is the gap width, $D (=2R)$, see FIG. 1A) is the rotor diameter, q is the fluid flowrate and V is the volume of fluid within the annular gap. The number of cycles N can be rewritten in the form

$$N = Ta(D/2d)^{1/2} \nu h/q \quad (33)$$

Thus, for fixed Taylor number Ta and gap width d such that the ratio of radiation penetration depth-to-boundary layer thickness λ/δ is a constant and for fixed fluid properties ν , one obtains

$$N \propto D^{1/2} h/q \quad (34)$$

Thus, scale-up of the reactor to larger rotor diameters D and longer rotors h is achieved for fixed N if

$$q \propto D^{1/2} h \quad (35)$$

EXAMPLE 7

UV Treatment System in Laminar Taylor-Couette Flow

An ultraviolet treatment system in laminar Taylor-Couette flow was further investigated for microbe disinfection. The results were published in *Optimum UV Disinfection between Concentric Cylinders*, I&EC Res., 47, (10), 3444-3452, 2008, which is incorporated herein by reference in its entirety as if fully set forth herein. The schematic diagram of the Taylor-Couette reactor employed is illustrated in FIG. 2 described above. The stator of the Taylor-Couette UV reactor was constructed of $\Phi_2=4.577$ cm internal diameter, fused quartz (Vycor, Corning Inc., Corning N.Y.) with an internal Teflon rotor of $\Phi_1=3.434$ cm outer diameter. The dimensions provided a fluid gap width of $d=0.5715$ cm. The radiation source consisted of 6 medium-pressure, mercury UVC lamps with diameters of 0.95 cm and effective lengths of $L=5.34$ cm (Pen-Ray Lamps, UVP, Upland, Calif.), which are evenly

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distributed around the outside of the quartz stator. Moreover, the UV lamps are surrounded with an aluminum reflector as shown in FIG. 2. The incident radiation fluence rate from the quartz surface into the fluid is assumed to be uniform where $I_0=25$ mW/cm². The Taylor number used to characterize the flow is defined as,

$$Ta = \frac{R_1 \Omega_1 d}{\nu} \left(\frac{d}{R_1} \right)^{1/2} \quad (36)$$

where R_1 is the radius of the inner cylinder, ψ_1 is the angular velocity of the inner cylinder, d is the gap width, and ν is the kinematic viscosity.

The solution used in the UV disinfection experiments in turbulent flow was commercial clarified apple juice (Ocean Spray, Lakeville-Middleboro, Mass.). The solutions used in the UV disinfection experiments in both laminar Poiseuille flow and laminar Taylor-Couette flow are model solutions⁶ For the latter, Caramel 050 (D.D. Williamson & Co., Inc., Louisville, Ky.) is added to adjust the absorption coefficient of the fluid.

The solutions inoculated with *E. coli* K12 (ATCC 25253) or *Yersinia pseudotuberculosis* (*Y. pseudotuberculosis*) are pumped into the reactor and irradiated in the gap. Each reactor is mounted in the vertical position with the fluid flowing from the bottom in order to fill the annular gap and avoid bubbles. Samples for microbial analysis are taken after steady state conditions are reached. The concentrations of viable microorganisms both before and after UV exposure are determined by a plate method.

UV Inactivation Kinetics

The first order inactivation model is the simplest used to describe UV inactivation kinetics. The model assumes that the inactivation rate changes with respect to pathogen concentration and fluence rate such that,

$$\frac{dN}{dt} = -k_1 IN \quad (37)$$

where k_1 is first order inactivation constant, cm²/mJ. If k_1 and I are constant, by integration,

$$\frac{N}{N_0} = \exp(-k_1 It). \quad (38)$$

Because a lag in microbial inactivation at low fluence (the shouldered survival curve) is often observed, the first order model can overestimate inactivation at low log reduction where $N-N_0$. Therefore, the series-event inactivation model presented by Severin et al.¹¹ was proposed to account for the lag at low fluence. The model assumes that the inactivation of microorganism elements takes place in a stepwise fashion and the rate at each step is first order with respect to the fluence rate I ,

$$\frac{dN_i}{dt} = k_{SE} I (N_{i-1} - N_i) \quad (39)$$

where k_{SE} is the inactivation rate constant in the series-event inactivation model and the subscript i is the event level. Here, k_{SE} is assumed to be the same for different event levels. When

n elements of the microorganism (a threshold) have been inactivated, the microorganisms will become nonviable. If k_{SE} and I are constant, the concentration of surviving microorganisms N is determined by

$$\frac{N}{N_0} = \exp(-k_{SE} I t) \sum_{i=0}^{n-1} \frac{(k_{SE} I t)^i}{i!} \quad (40)$$

where n is a threshold. It is clear that if $n=1$, the above equation reduces to the first order model.

Recently, Ye et al.¹² records that the inactivation parameters of *E. coli* K12 are $k_1=0.325$ cm²/mJ and $k_{SE}=0.675$ cm²/mJ with a threshold $n=4$ and the inactivation parameters of *Y. pseudotuberculosis* are $k_1=0.557$ cm²/mJ and $k_{SE}=0.984$ cm²/mJ with a threshold $n=3$.

Numerical Simulation

UV Disinfection in Laminar Poiseuille Flow

The UV fluence rate in the annular gap can be approximated by Lambert-Beer's law. If the radiation comes from the inner cylinder, the fluence rate at the radius r becomes

$$I(r) = I_0 \frac{R_1}{r} \exp(-\alpha(r - R_1)) \quad (41a)$$

where α is the absorbance coefficient (e base), cm⁻¹, I_0 is incident fluence rate and R_1 is the radius of the inner cylinder. If the radiation comes from the outer cylinder,

$$I(r) = I_0 \frac{R_2}{r} \exp(-\alpha(R_2 - r)) \quad (41b)$$

where R_2 is the radius of the outer cylinder.

The governing equations of fluid flow and microorganism concentration can be simplified depending on the flow patterns. For laminar Poiseuille flow¹³ it can be assumed that only an axial velocity component u_z exists and changes with azimuthal angle

$$\frac{\partial}{\partial \theta} = 0.$$

Then

$$u_z(r) = C_1 \left[1 - \frac{r^2}{R_2^2} + \frac{1 - \kappa^2}{\ln(1/\kappa)} \ln\left(\frac{r}{R_2}\right) \right] v. \quad (42)$$

The average concentration of viable microorganisms at the outlet of the reactor N can now be obtained by numerical integration. For example, if the series-event inactivation model is used,

$$\int_{R_1}^{R_2} \exp(-k_{SE} I(r) L / u_z(r)) \quad (43)$$

$$\frac{N}{N_0} = \frac{\sum_{i=0}^{n-1} \frac{(-k_{SE} I(r) L / u_z(r))^i}{i!} u_z(r) r dr}{\int_{R_1}^{R_2} u_z(r) r dr}$$

UV Disinfection in Turbulent Flow

For turbulent flow, the k - ϵ model is used to simulate turbulence and it can also be assumed that only radial and axial velocity components exist and

$$\frac{\partial}{\partial \theta} = 0.$$

Then, the governing equations of fluid flow and microorganism concentrations in cylindrical coordinate can be written as¹⁴

$$\frac{1}{r} \frac{\partial(r u_r)}{\partial r} + \frac{\partial u_z}{\partial z} = 0 \quad (44)$$

$$\frac{1}{r} \frac{\partial(r \rho u_r \phi)}{\partial r} + \frac{\partial(\rho u_z \phi)}{\partial z} = \frac{1}{r} \frac{\partial}{\partial r} \left(r (\mu + \mu_t) \frac{\partial \phi}{\partial r} \right) + \frac{\partial}{\partial z} \left((\mu + \mu_t) \frac{\partial \phi}{\partial z} \right) + S_\phi \quad (45)$$

$$u_r \frac{\partial N_i}{\partial r} + u_z \frac{\partial N_i}{\partial z} = \frac{\mu_t}{\rho S_{ci}} \left(\frac{1}{r} \frac{\partial}{\partial r} \left(r \frac{\partial N_i}{\partial r} \right) + \frac{\partial^2 N_i}{\partial z^2} \right) + k_{SE} I (N_{i-1} - N_i) \quad (46)$$

Here, ρ is density, μ_t is turbulent viscosity and ϕ in equation (45) can be either u_r , u_z , k or ϵ . The source term S_ϕ in equation (45) is different depending on the definition of ϕ . Sc_t is the turbulent Schmidt number relating the ratio of the turbulent momentum transport to the turbulent mass transport where the recommended value of Sc_t is 0.8¹⁴.

UV Disinfection in Laminar Taylor-Couette Flow

For laminar Taylor-Couette flow, the governing equations of fluid flow and microorganism concentrations in cylindrical coordinate can be written as¹³

$$\frac{1}{r} \frac{\partial(r u_r)}{\partial r} + \frac{1}{r} \frac{\partial u_\theta}{\partial \theta} + \frac{\partial u_z}{\partial z} = 0 \quad (47)$$

$$\frac{\partial \phi}{\partial t} + \frac{1}{r} \frac{\partial(r u_r \phi)}{\partial r} + \frac{1}{r} \frac{\partial(u_\theta \phi)}{\partial \theta} + \frac{\partial(u_z \phi)}{\partial z} =$$

$$\frac{1}{r} \frac{\partial}{\partial r} \left(r v \frac{\partial \phi}{\partial r} \right) + \frac{1}{r} \frac{\partial}{\partial \theta} \left(r \frac{\partial \phi}{\partial \theta} \right) + v \frac{\partial^2 \phi}{\partial z^2} + S_\phi$$

$$\frac{\partial N_i}{\partial t} + u_r \frac{\partial N_i}{\partial r} + \frac{u_\theta}{r} \frac{\partial N_i}{\partial \theta} + u_z \frac{\partial N_i}{\partial z} =$$

$$D \left(\frac{1}{r} \frac{\partial}{\partial r} \left(r \frac{\partial N_i}{\partial r} \right) + \frac{1}{r^2} \frac{\partial^2 N_i}{\partial \theta^2} + \frac{\partial^2 N_i}{\partial z^2} \right) + k_{SE} I (N_{i-1} - N_i) \quad (49)$$

where ϕ in equation (48) can be either u_r , u_θ or u_z . The source term S_ϕ is again different depending on the definition of ϕ . Since the molecular diffusion coefficient D is small in equation (49), these diffusion terms can normally be neglected.

Comparison Between Experimental Results and Numerical Simulation

FIG. 14 is the comparison of *E. coli* inactivation between experimental results and numerical simulations for the 77.9 cm reactor in laminar Poiseuille flow. FIG. 14 illustrates that numerical simulations agree well with experimental results.

FIG. 15 is the comparison of *Y. pseudotuberculosis* inactivation between experimental results and numerical simulations in turbulent flow (axial hydraulic Re_h $2\rho v d/\mu=2000$) with four reactors connected in series. The juice absorption coefficient is $A=7.155\text{ cm}^{-1}$ and the flow rate is $Q=120\text{ mL/s}$. The small deviation between experimental results and numerical simulations in FIG. 15 was probably caused by the assumption that perfect mixing occurs in the connection tubing between two reactors in series.

FIGS. 16 to 18 are the comparison of *E. coli* inactivation between experimental results and numerical simulations in laminar Taylor-Couette flow with different Taylor numbers, average residence times and penetration depths, respectively. The penetration depth λ is defined as the path length at which the fluence rate is 10% of the incident radiation fluence rate, namely, $\lambda=-\log_{10}(10^{-1})/A$ or $\lambda=1/A$. The results of FIGS. 16 to 18 show that the numerical simulations agree well with experimental results with different operating conditions.

These results suggest that the numerical simulations can predict experimental disinfection in laminar Poiseuille, turbulent and laminar Taylor-Couette flows. Thus, numerical methods will be used to calculate the optimum gap width and compare disinfection among the three flow patterns.

Correlation of UV Disinfection in Turbulent and Taylor-Couette Reactors

If turbulent and Taylor-Couette reactors can be approximated as ideal plug flow reactors (PFRs) and the first order inactivation model is used, the microbe inactivation is

$$\ln\left(\frac{N}{N_0}\right) = -k_1 I_{av} \tau. \quad (50)$$

Here, the average fluence rate is determined by integrating Equation 41a or

$$I_{av} = \frac{2\pi \int_{R_1}^{R_2} I_o \frac{R_1}{r} \exp(-\alpha(r - R_1)) r dr}{2\pi \int_{R_1}^{R_2} r dr} \quad (51)$$

$$= \frac{I_o R_1 [1 - \exp(-\alpha(R_2 - R_1))]}{0.5\alpha(R_2^2 - R_1^2)}.$$

In equations (50) and (51), $\tau=L/v$ and the radiation is assumed to irradiate from the inner cylinder. Substitution of equation (51) into equation (50) gives

$$\ln\left(\frac{N}{N_0}\right) = -k_1 \frac{R_1 [1 - \exp(-\alpha(R_2 - R_1))]}{0.5\alpha(R_2^2 - R_1^2)} I_o \tau. \quad (52)$$

For normal values of $\alpha(R_2 - R_1) > 5$ and $\exp(-\alpha(R_2 - R_1)) < <1$, equation (52) can be simplified further such that

$$\ln\left(\frac{N}{N_0}\right) = -\frac{k_1 I_o \tau R_c}{\alpha d}. \quad (53)$$

where the gap width $d=R_2-R_1$ and a new dimensionless group is defined as

$$R_c = \frac{2R_1}{R_2 + R_1}. \quad (54a)$$

Equation (54a) is introduced if the radiation comes from the inner cylinder. If the radiation comes from the outer cylinder,

$$R_c = \frac{2R_2}{R_2 + R_1}. \quad (54b)$$

To correct for the effects of the fluid boundary near the radiation surface, it is convenient to add the ratio c/δ to equation (53) where δ is the boundary layer thickness. Thus, equation (53) is modified as,

$$\ln\left(\frac{N}{N_0}\right) = -\frac{ck I_o \tau R_c}{\alpha d \delta}. \quad (55)$$

The boundary layer thickness δ for turbulent flow in equation (55) is calculated according to equation (56) from Middleman¹⁵

$$\delta = \frac{2\mu}{\rho v f} \quad (56)$$

where f is the dimensionless shear stress or friction factor. According to boundary layer theory¹⁶ the friction factor f can be approximated by

$$f=0.079 Re_h^{-0.25} \quad (57)$$

where Re_h =the $\rho v d/\mu$ is the hydraulic Reynolds number for flow between concentric cylinders. In contrast, for laminar Taylor-Couette flow the boundary thickness δ is proportional to $Ta^{-1/2}$ from the work of Baier et al.¹⁷ and Forney et al.^{8,9} where

$$\delta = \frac{2d}{\sqrt{Ta}}. \quad (58)$$

The experimental data of both turbulent and laminar Taylor-Couette reactors are correlated with the same dimensionless group as shown in FIG. 8. Here, the constant $c=0.0125\text{ cm}$ in equation (55) for the solid line is obtained by the least squares method. The standard deviation between the data and Equation 55 is minimized such that $\sigma_y=0.283$ and the coefficient of determination $R^2=0.973$ in FIG. 19. FIG. 19 shows that the same correlation equation can be used to predict UV disinfection for both turbulent and laminar Taylor-Couette reactors. Similarly, the numerical results of both turbulent reactors and laminar Taylor-Couette reactors are correlated with equation (55) and are shown in FIG. 20

Optimum Gap Width

Gap width is one of the most important parameters for the design of thin film annular UV reactors. For simplicity one considers radiation from both the inner and outer walls of a concentric cylinder geometry as shown in FIG. 21. Tracing a path across the fluid gap provides profiles of possible radiation intensity that are shown in FIG. 21. For example, microbes at the center of the gap are subjected to a small radiation intensity that is shown on a single curve at the center of FIG. 21. Moreover, microbes near the wall experience a larger radiation intensity. Consider constant flow rate in FIG. 21 where the fluid velocity v is inversely proportional to the gap width or $v \propto 1/d$. Thus contours at the top of FIG. 21, where the gap width d is small, subject microbes to a large radiation intensity but short residence times. Conversely, if d is large, microbes across the gap are subject to a small radiation intensity representative of the bottom contour in FIG. 21 but large residence times. Thus, the average dosage of photons $I_0 \tau$ is low on both the top and bottom contours of FIG. 21 but high for intermediate contours for both laminar, turbulent and Taylor-Couette flows.

FIGS. 22 to 24 show how microbe inactivation levels change with λ/d when the radius of inner cylinder is constant at 1.225 cm and radiation comes from the inner cylinder. The radius of the outer cylinder is changed to create different gap widths. According to FIGS. 22 to 24, there is an optimum gap width for each absorption coefficient. Although the optimum λ/d is somewhat different because of different conditions such as absorption coefficients and flow patterns, the optimum λ/d oscillates around a fixed value for each flow pattern. The optimum λ/d for laminar Poiseuille flow, turbulent flow and laminar Taylor-Couette flow are 1.5, 1 and 0.5, respectively.

For laminar Poiseuille flow, the optimum $\lambda/d=1.5$ in FIG. 22. When $\lambda/d<1.5$, a longer residence time results in pathogens that are partially over exposed to the radiation source. However, disinfection of the over exposed fraction near the radiation source cannot offset the increase in surviving pathogens of the under exposed fraction across the wider gap width. According to FIG. 22, inactivation levels decrease greatly when $\lambda/d<1.0$. For example when $\lambda/d=0.2$, the inactivation level is about 5% of the optimum. Finally, since $\lambda=1/A$, FIG. 22 can be used to design a laminar UV reactor to achieve a 5 log reduction where $\lambda/d \sim 1.0$.

There is an optimum gap width for each absorption coefficient in turbulent flow as was the case for laminar flow. FIG. 23 shows how *Y. pseudotuberculosis* microbe reductions change with gap width when the radius of the inner cylinder is constant at 1.225 cm while the radius of the outer cylinder is changed. In FIG. 23 the series event model is used with $k_{SE}=0.984 \text{ cm}^2/\text{mJ}$ and $n=3$ and radiation comes from the inner cylinder with a fluence rate of $I_0=800 \text{ mW/cm}^2$ for a UV lamp length of $L=29.2 \text{ cm}$.

From FIG. 23, it is shown that the optimum $\lambda/d \sim 1.0$ for turbulent flow and does not change dramatically for different absorption coefficients. As shown, the penetration depth equals the gap width for optimum disinfection in turbulent flow or the radiation has to penetrate across the gap to obtain optimum disinfection. This requirement is caused by the under irradiated region in the viscous sublayer¹⁸ on the opposite side of the radiation source. Though the under irradiated region occupies only a small fraction of the gap, about 5% or less, surviving pathogens in the under irradiated region contribute to the population of surviving pathogens within the gap. Because most of pathogens in the under irradiated region survive if $\lambda/d \ll 1$, the average concentration of the surviving pathogen at the outlet will be about $0.05 N_0$. Since the normal

absorption coefficients of juices are $10\text{--}40 \text{ cm}^{-1}$, the optimum gap width is in the range of 0.25–1.0 mm. Therefore, the gap width of turbulent UV reactors used for juice disinfection should not be more than 1.5 mm.

One method to improve the performance of the turbulent UV reactor and to eliminate the viscous sublayer problem is to irradiate from both of the cylinders. Another method is to connect the UV reactors in series. In the latter case, pathogens in the viscous sublayer in the first UV reactor may enter the fully turbulent region in the next reactor. Moreover, the short residence time for turbulent flow conditions may also require that one connect several reactors in series.

FIG. 24 illustrates that optimum inactivation occurs at a ratio of $\lambda/d=0.5$ for all fluids in Taylor-Couette flow. As is the case with both laminar and turbulent flows, the inactivation level of microbes in Taylor-Couette flow is affected by the absorbance $A=1/\lambda$, in particular, the ratio of penetration depth to gap width λ/d . For example, if one wishes to achieve a 5 log reduction ($N/N_0=10^{-5}$) in viable microbes with the Taylor-Couette device, the design would require a somewhat larger gap width with $\lambda/d<0.5$. Because the normal absorption coefficients of juices are $10\text{--}40 \text{ cm}^{-1}$, the optimum gap width is in the range of 0.5–2.0 mm. Therefore, the gap width of Taylor-Couette UV reactors used for juice disinfection should not be more than 3 mm. As seen from FIG. 24, when operating with laminar Taylor-Couette flow the preferred operating range for λ/d is less than 0.5, more preferably in the range of about 0.2 to about 0.3 in order to achieve log reduction of about 10^{-5} , and even more preferably approximately 0.25 to achieve such a log reduction.

Optimum Inactivation Among Three Flow Patterns

Because of different requirements for the three flow patterns, it is impossible to compare microbe inactivation at the same conditions such as flow rate. However, theoretical predictions suggest similar inactivation levels for the same radii of the cylinders, pathogen and fluence $I_0 \tau$. FIG. 25 is the comparison of log reductions among the three flow patterns, where the radius of the inner cylinder is 1.225 cm and series-event inactivation model of *E. Coli* is used. In FIG. 25, the radius of the outer cylinder is changed from 1.235 cm to 1.74 cm in order to create different gap widths.

According to FIG. 25, laminar Taylor-Couette flow is superior to either turbulent or laminar Poiseuille flow in at least the following aspects:

1. Laminar Taylor-Couette flow achieves superior inactivation levels than either laminar Poiseuille or turbulent flow with the same dosage $I_0 \tau$, absorption coefficient A and flow rates. For example, when $A=40 \text{ cm}^{-1}$ and $\lambda/d=0.417$, the inactivation levels $N/N_0=8.2 \times 10^{-10}$, 8.1×10^{-3} and 0.27 for laminar Taylor-Couette flow ($Ta=200$), turbulent and laminar Poiseuille flow, respectively. Both turbulent and laminar Poiseuille flows achieve small inactivation levels when the absorption coefficients of juices are high and λ/d is small. For example, when $A=40 \text{ cm}^{-1}$ and $\lambda/d=0.049$, the inactivation levels N/N_0 are 0.81 and 0.95 for turbulent flow and laminar Poiseuille flow, respectively. However, $N/N_0=0.097$ for laminar Taylor-Couette flow ($Ta=200$).
2. As stated earlier, the optimum λ/d for laminar Taylor-Couette flow is reduced to 0.5 compared with the optimum λ/d of 1.5 and 1.0 for laminar Poiseuille and turbulent flow, respectively. Thus, laminar Taylor-Couette flow is suitable for disinfecting juices with large absorption coefficients.

Fluence Distribution Function Among Three Flow Patterns

One objective with the design of UV reactors is to provide an equal flux of photons to each microbe. Providing a uniform

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photon flux to each microbe is difficult because of the attenuation of the photon flux with distance from the radiation source near the wall. The only way to overcome a non-uniform photon flux is to provide sufficient microbe transport or mixing within the fluid gap. FIG. 26 illustrates fluid stream-

lines containing microbes that result from Taylor-Couette flow. One method of comparing the effects of different flow patterns within a plug flow reactor is to determine the fluence distribution. The fluence distribution is computed by following a large number of microbes through the reactor while summing the number of photons incident on each microbe.

FIG. 27 is the fluence distribution function of the three flow patterns when $\lambda/d=0.25$. The fluence distribution function is defined as the fraction of fluids leaving the reactor that has fluence of $(\log It, \log It+d(\log It))$

$$\frac{E(\log It)d(\log It)}{(\log It, \log It+d(\log It))} = \text{Fraction of fluids with fluence of } (59)$$

where the fluence It is made dimensionless by the average fluence of an ideal plug flow reactor (see Equation (51)). The fluence distribution function $E(\log It)$ is defined by the expression given by Forney et al.¹⁰

$$E(\log It) = \frac{1}{N_T} \frac{dN}{d(\log It)} \quad (60)$$

In FIG. 27 the area under the curve for each reactor design represents all microbes tracked for each design or $\int E(\log It)d(\log It)=1$. In simple terms, reactor designs with the highest peaks in the distribution function are superior. In such designs all microbes are subject to a nearly uniform number of photons and the required incident radiation flux for inactivation is reduced.

According to FIG. 27, Taylor vortex reactors approach the superior characteristics of a PFR. Moreover, for turbulent flow, there are three peaks. The left peak corresponds to the effect of the viscous sublayer on the opposite side of the radiation source while the right peak corresponds to the effect of the viscous sublayer near the radiation source. Finally, the middle peak corresponds to the effect of the fully turbulent region.

As can be seen, UV disinfection between concentric cylinders in laminar Poiseuille flow, turbulent flow and laminar Taylor-Couette flow was investigated both experimentally and numerically. The numerical simulations agree well with experimental results. Laminar Taylor-Couette flow is superior to either turbulent or laminar Poiseuille flow for at least the following reasons¹⁹: (1) laminar Taylor-Couette flow achieves larger log reduction levels than either laminar Poiseuille or turbulent flow with the same dosage $I_0\tau$, pathogen and cylinder radii; and (2) the optimum λ/d for laminar Taylor-Couette flow is reduced to 0.5 compared with the optimum λ/d of 1.5 and 1.0 for laminar Poiseuille flow and turbulent flow, respectively.

Therefore, laminar Taylor-Couette reactors are suitable for processing a variety of juices, especially those with large absorption coefficients. In contrast, for laminar Poiseuille flow, the optimum gap width is very small in the absence of radial mixing. Inactivation decreases sharply if the gap width of the reactor is larger than the optimum. The laminar Poiseuille reactors are suitable for water or wastewater, for which the absorption coefficient is small. Improvements in the performance of laminar UV reactors are achieved in practice by redistributing the fluid at two or more locations along the reactor axis⁶.

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For turbulent flow, the high flow rate to ensure turbulence is coupled with a reduced residence time. The turbulent reactors are suitable for processing large quantities of juice, for which penetration depth is much larger than the viscous sublayer thickness.

Turbulent Taylor-Couette Flow

Experiments by Lueptow et al.³ show that the flow pattern in the annular gap will change from laminar Taylor-Couette to turbulent Taylor-Couette flow with an increase in Taylor number. FIG. 28 are the log reductions of *E. Coli* including laminar and turbulent Taylor-Couette flow. In FIG. 28, the axial Reynolds numbers are 6.4 and 12.8 for flow rates 0.3 mL/s and 0.6 mL/s, respectively. The radii of the inner and outer cylinder are 1.225 cm and 1.74 cm, respectively. The length of the UV lamp is 11.2 cm and UV is irradiated from the inner cylinder with an intensity of 12 mW/cm². In FIG. 28, the series-event inactivation model of *E. coli* is used and the absorption coefficient is assumed to be $A=20 \text{ cm}^{-1}$. Since it is difficult to determine the exact Taylor number at which the transition from laminar to turbulent flow occurs³, both laminar and turbulent simulation results with $Ta=600$ are provided.

In laminar Taylor-Couette flow, the inactivation levels increase with Taylor number as shown in FIG. 16. In FIG. 28 it is shown that log reductions in turbulent Taylor-Couette flow do not increase with Taylor number. On the contrary, the log reductions in turbulent Taylor-Couette flow will decrease with an increase in Taylor number where the latter is caused by axial turbulent mixing. Turbulent Taylor-Couette flow increases both the radial and axial mixing where the latter should be avoided in the thin film annular reactors. The axial mixing at large Ta number is a kind of back mixing and will reduce disinfection results. With the increase in Taylor number in turbulent Taylor-Couette flow, the flow pattern is approaching that of a continuous stirred tank reactor (CSTR) as demonstrated by Resende et al.²⁰ By contrast, the axial mixing is negligible in laminar Taylor-Couette flow which can be approximated by an ideal plug flow reactor (PFR) as shown by Kataoka et al.²¹ Therefore, the Taylor vortex reactors should be operated in laminar Taylor-Couette flow as opposed to turbulent Taylor-Couette flow and, in some situations, with Taylor numbers as high as possible²² while still operating in laminar Taylor-Couette flow.

In contrast to FIG. 6 discussed above, FIG. 28 suggests a Taylor number of above 400, but below that for turbulent flow may be preferred under certain conditions. The material tested in connection with FIG. 6 included a colloidal material, bentonite, that affects the properties of the fluid being disinfected. In particular, at high RPMs the colloidal material, silica in bentonite, moves to the outside of the annular channel affecting the outside of the annular channel. This provides different results at higher stator RPM, causing a shift to a lower Taylor number. FIG. 28 provides results when a colloidal material, such as bentonite, is not included in the fluid to be disinfected. In particular, FIG. 28 shows that a Taylor number greater than about 400, but below the Taylor number for turbulent Taylor-Couette flow is desirable, and more particularly a Taylor number of about 500 to about 600 is desirable. FIG. 28 shows that for a Reynolds number of 12.8, the residence time of the fluid in the Taylor-Couette reactor is not as effective as when operating at the lower Reynolds number of 6.4. In either case, however, improved results are achieved at a Taylor number of about 400 up to about 600 when operating at laminar flow as opposed to operating turbulent Taylor-Couette flow.

It should be emphasized that the above-described embodiments of the present disclosure, particularly, any "preferred"

embodiments, are merely possible examples of implementations, merely set forth for a clear understanding of the principles of the invention. Many variations and modifications may be made to the above-described embodiment(s) without departing substantially from the spirit and principles of the present disclosure. All such modifications and variations are intended to be included herein within the scope of this disclosure and the present invention and protected by the following claims.

Nomenclature

A =	absorption coefficient with 10 base, cm^{-1} , $I_x = I_o \times 10^{(-Ax)}$
c =	a constant to correct for deviations between reactors, cm
$C_1 =$	constant determined by κ , $C_1 = \frac{2}{1 + \kappa^2 - (1 - \kappa^2)/\ln(1/\kappa)}$
d =	gap width, cm
f =	dimensionless shear stress, Pa
i =	event level
$I_o =$	incident fluence rate, mW/cm^2
$I(r) =$	fluence rate at a position in the gap r, mW/cm^2
$I_t =$	fluence, mJ/cm^2
$I_{av}\tau =$	average fluence of ideal plug flow reactor, mJ/cm^2
k =	turbulent kinetic energy, m^2/s^2 or inactivation constant, cm^2/mJ
$k_1 =$	inactivation constant of the first inactivation model, cm^2/mJ
$k_{SE} =$	inactivation constant of the series-event inactivation model, cm^2/mJ
L =	length of radiation section, cm
n =	threshold for inactivation in the series-event model
N =	concentration of viable microorganisms, CFU/mL
$N_o =$	concentration of viable microorganisms before exposure, CFU/mL
$N_i =$	concentration of viable microorganisms at event level i, CFU/mL
Q =	volumetric flow rate, mL/s
r =	radius, cm
$R_1 =$	radius of inner cylinder, cm
$R_2 =$	radius of outer cylinder, cm
Rc =	dimensionless group
$Re_h =$	hydraulic Reynolds number, $2d\rho v/\mu$
$S_\Phi =$	source terms depending on the definition of Φ
$Sc_\tau =$	turbulent Schmidt number
t =	time, s
Ta =	Taylor number
$u_r =$	radial velocity component, cm/s
$u_z =$	axial velocity component, cm/s
$u_\theta =$	azimuthal velocity component, cm/s
$u_\tau =$	friction velocity, m/s
v =	average velocity, cm/s or m/s, $= \frac{Q}{\pi(R_2^2 - R_1^2)}$
z =	axial coordinate, cm
$\alpha =$	absorption coefficient with e base, cm^{-1} , $I_x = I_o \exp(-\alpha x)$
$\epsilon =$	dissipation rate, m^2/s^3
$\delta =$	boundary layer thickness, cm outer cylinder, $\kappa = R_1 R_2$ outer cylcl;lkasid
$\theta =$	angle around the cylinder, degree, $0 \leq \theta \leq 2\pi$
$\kappa =$	ratio of the radius of the inner cylinder to that of outer cylinder, $\kappa = R_1/R_2$
$\lambda =$	penetration depth, cm, $\lambda = 1/\Lambda$
$\mu =$	dynamic viscosity, Pa · s
$\mu_\tau =$	turbulent viscosity, Pa · s
$\nu =$	kinematic viscosity, m^2/s
$\rho =$	density, kg/m^3
$\tau =$	average residence time, s, $= L/v$
$\theta =$	variable in governing equations
$\Omega_1 =$	angular velocity of inner cylinder, s^{-1}
$\Phi_1 =$	outer diameter of inner cylinder, cm
$\Phi_2 =$	inner diameter of outer cylinder, cm

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What is claimed is:

1. A method for disinfecting an edible fluid comprising: providing a fluid reactor including
 - an annular wall having an inside wall surface;
 - a rotor having an wall surface placed within the annular wall, the inside wall surface of the outer annular wall and the outer wall surface of the rotor forming an annular fluid channel;
 - at least one of the inside wall surface of the annular wall and the outer wall surface of the rotor having a corrugated surface;
 - a fluid inlet in the annular wall in communication with the annular fluid channel;
 - a fluid outlet in the annular wall also in communication with the annular fluid channel;
 - introducing the edible fluid comprising a micro-organism into the annular fluid channel;
 - controlling rotation of the rotor to provide laminar Taylor-Couette vortices in the fluid in the annular fluid channel; and
 - irradiating the edible fluid in the annular fluid channel with an anti-microbial amount of energy.
2. The method of claim 1, wherein the step of controlling rotation of the rotor to provide laminar Taylor-Couette vortices provides a Taylor number of about 600 or less.
3. The method of claim 1, wherein the step of controlling rotation of the rotor to provide laminar Taylor-Couette vortices provides a plurality of circumferential vortices within the annular fluid channel.
4. The method of claim 1, wherein the step of irradiating the edible fluid in the annular fluid channel is accomplished by providing an energy source in the form of a lamp for providing ultraviolet light.
5. The method of claim 1, wherein the fluid comprises wastewater.
6. The method of claim 1, wherein the edible fluid comprises milk, fruit juice, or a beverage.
7. The method of claim 1, wherein a fluid gap width is formed in the annular fluid channel between the inside wall surface of the annular wall and the outer wall surface of the rotor across the annular fluid channel, wherein the energy penetrates to a depth across the fluid gap, and wherein the ratio of the depth of penetration of the energy to a width of the fluid gap is from about 0.2 to about 0.3 to achieve a log reduction of 10^{-5} .
8. The method of claim 1, wherein the fluid reactor comprises a plurality of fluid annular channels.
9. A method for disinfecting an edible fluid comprising: providing a fluid reactor including
 - an annular wall having an inside wall surface;
 - a rotor having an wall surface placed within the annular wall, the inside wall surface of the outer annular wall and the outer wall surface of the rotor forming an annular fluid channel;
 - at least one of the inside wall surface of the annular wall and the outer wall surface of the rotor having a corrugated surface;
 - a fluid inlet in the annular wall in communication with the annular fluid channel;
 - a fluid outlet in the annular wall also in communication with the annular fluid channel;

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- introducing the edible fluid comprising a micro-organism into the annular fluid channel;
- controlling rotation of the rotor to provide laminar Taylor-Couette vortices in the fluid in the annular fluid channel; and
- irradiating the edible fluid in the annular fluid channel with an anti-microbial amount of energy, wherein a fluid gap width is formed in the annular fluid channel between the inside wall surface of the annular wall and the outer wall surface of the rotor across the annular fluid channel, wherein the energy penetrates to a depth across the fluid gap, and wherein the ratio of the depth of penetration of the energy to a width of the fluid gap is less than about 0.5.
10. A method of disinfecting a fluid including an organism comprising:
 - passing the fluid between two surfaces at least one of the surfaces having a corrugated surface;
 - forming laminar Taylor-Couette vortices in the fluid between the two surfaces, wherein the fluid between the two surfaces has a fluid flow having a Taylor number such as to provide laminar vortices; and
 - irradiating the fluid between the two surfaces with an anti-microbial amount of energy.
11. The method of claim 10, wherein the Taylor number is from about 400 to about 600.
12. The method of claim 11, wherein the organism comprises bacteria, fungi, protozoa, viruses, or a combination thereof.
13. The method of claim 11, wherein the energy is electromagnetic energy.
14. The method of claim 11, wherein the fluid comprises wastewater.
15. The method of claim 11, wherein the fluid comprises an edible fluid.
16. The method of claim 15, wherein a fluid gap width is formed between the two surfaces, wherein the energy penetrates to a depth across the fluid gap, and wherein the ratio of the depth of penetration of the energy to a width of the fluid gap is less than about 0.5.
17. The method of claim 16, further including rotating at least one of the surfaces about an axis of rotation such that the axis of rotation of the surface is substantially parallel to the flow of the fluid.
18. The method of claim 11, wherein a fluid gap width is formed between the two surfaces, wherein the energy penetrates to a depth across the fluid gap, and wherein the ratio of the depth of penetration of the energy to a width of the fluid gap is from about 0.2 to about 0.3 to achieve a log reduction of 10^{-5} .
19. The method of claim 18, further including rotating at least one of the surfaces about an axis of rotation such that the axis of rotation of the surface is substantially parallel to the flow of the fluid.
20. The method of claim 10, further including rotating at least one of the surfaces about an axis of rotation such that the axis of rotation of the surface is substantially parallel to the flow of the fluid, wherein the Taylor number is about 600 or below.

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